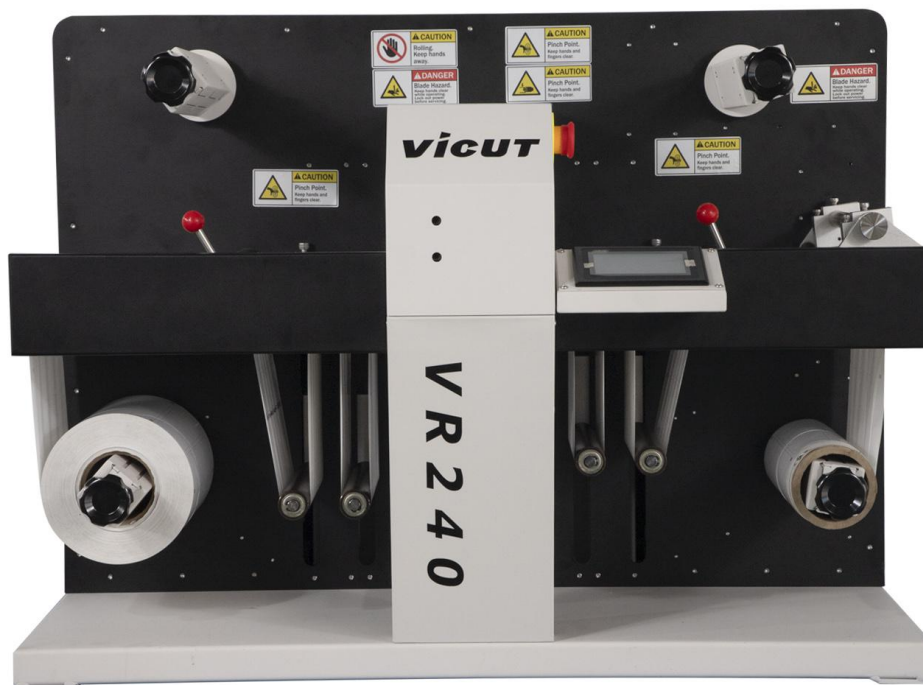


VR240 Digital Label Die Cutter User Manual



Please read this manual before you use this equipment be carefully.

ANHUI William(VICUT) CNC Technology Co., LTD
Version: revised 2020/12

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INDEX

| | |
|---|----|
| Chapter 1 Safety Matter----- | 1 |
| 1-1 Safety matter needing attention----- | 2 |
| 1-2 Caution labels----- | 3 |
| 1-3 Safety attention instruction----- | 4 |
| Chapter 2 Handling and installation.----- | 5 |
| 2-1 Crate Handling----- | 5 |
| 2-2 Crate Disassemble----- | 5 |
| 2-3 Storage requirements----- | 5 |
| 2-4 Machine Handling----- | 5 |
| 2-5 Space requirements----- | 5 |
| 2-6 Electric and pneumatic----- | 5 |
| 2-7 Installation procedure----- | 5 |
| Chapter 3 System Introduction----- | 6 |
| 3-1 Functions introduction----- | 6 |
| 3-2 Packing list----- | 7 |
| 3-3 Specification----- | 8 |
| Chapter 4 Preparation Work----- | 9 |
| 4-1 Media loading----- | 9 |
| 4-2 Sensor setup----- | 11 |
| 4-3 Lamination setup----- | 13 |
| 4-4 Cutting holder setup----- | 14 |
| 4-4-1 Cutting unit assembly----- | 14 |
| 4-4-2 Replace blade----- | 15 |
| 4-4-3 Adjust blade depth----- | 15 |
| 4-5 Waster removal setup----- | 16 |
| 4-6 Slitting unit setup----- | 17 |
| 4-7 Rewinder setup----- | 17 |

| | |
|---|----|
| Chapter 5 System Operating Instruction----- | 18 |
| 5-1 Operation instruction of control panel----- | 18 |
| 5-1-1 Panel button instruction----- | 18 |
| 5-1-2 Function instruction----- | 21 |
| 5-2 Work flow diagram----- | 23 |
| 5-2-1 Requirements for printing file----- | 23 |
| 5-2-2 Requirements for cutting file----- | 23 |
| 5-2-3 Cutting Software Setup----- | 25 |
| Chapter 6 Getting started----- | 42 |
| Chapter 7 Equipment maintenance----- | 45 |
| Chapter 8 Warranty----- | 48 |

Chapter 1 Safety Matter

1-1 Safety matter needing attention

1. The operator should obey the following 4 basic safety operation principles:

- (1) The machine should be operated or maintained only by trained technician.
- (2) Read the user manual in detail and understand its contents.
- (3) For check convenience, put the user manual near the machine.
- (4) The people including operator and maintenance technician should know location of E-stop device and realize its function and operation methods.

2. Safety precaution before or after turning on the machine:

Firstly confirm that whether all switches are OFF, and machine has been correctly ground with AC electric power source.

The electric power source used on this machine is 110V-220V~. Rated current of the main power switching device 20A. Such switching device should be in compliance with its safety relevant standards.

3. Safety precaution during handling and installation:

To increase the machine working efficiency, the installation environment should be well ventilated with good air quality. The surrounding temperature should be lower than 40 °C, and prevention of rain and direct sunlight is required.

Safety precautions during handling and installation are as follows:

- (1) Make sure that the foundation is strong enough to support the machine.
- (2) Lifting operation is only allowed one person.
- (3) When lifting the machine, nobody is allowed to be under or near the machine.
- (4) Helmet is required during handling, installation or cleaning.
- (5) If it's necessary to climb on the machine, please use safe and secure ladder or platform.
- (6) Adopt proper device for heavy parts lifting.
- (7) Confirm that whether the lifting wire rope is strong enough to lift the machine or components.
- (8) Please turn off the power before handling or installation. If power is required, let others know the location of E-stop device in advance.
- (9) Please wear leather gloves or other similar protective equipment during handling.

4. Safety precaution during operation:

The operator should be familiar with machine's function characteristics and operation methods. Don't let other people approach the machine. During running, stretch hands into work area is prohibited. If there is any abnormal situation happened, turn off the power immediately. After that, try to find the solutions.

Safety precautions during operation are as follows:

- (1) Don't remove any safety guarding or devices.
- (2) Don't remove or change location of any interlocking mechanism.
- (3) Prevent wet hands to touch switches.
- (4) Don't put any part of human body on or near the machine's moving parts.
- (5) Keep your hair away from moving parts.
- (6) Don't wear bangle, watch, jewelry or loose clothes.
- (7) Except material loading/unloading, it's not necessary to wear gloves.
- (8) Generally an operator is required for this machine. If more than one operator is required, there should be good communication between operators.




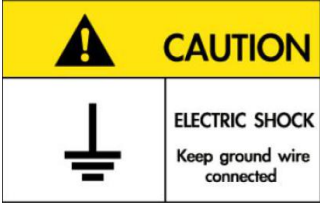

5. Safety precaution during maintenance:

Please turn off the power before maintenance.

Safety precautions during maintenance are as follows:

- (1) Turn off the main power before inspection or maintenance.
- (2) Maintenance or inspection should be carried out by authorized technician.
- (3) It's prohibited to climb the machine.
- (4) Please use the recommended lubricant or grease.

1-2 Cautions labels

| | |
|---|---|
|  | <p>Improper operation can cause casualties and equipment damage</p> |
|  | <p>Improper operation can cause casualties and other objects damage</p> |
|  | <p>Improper operation can cause casualties and equipment damage</p> |
|  | <p>Improper operation can cause casualties and equipment damage</p> |
|  | <p>Improper operation can cause casualties and equipment damage</p> |

1-3 Safety attention instruction

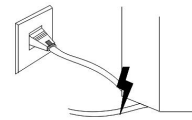


Don't touch the top end of knives.

Otherwise, fingers will be injured.

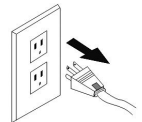


Don't damage and change original power wire and plug. The power cord should not be excessively bent, strong tension, bundling and compression under heavy loads. This will make power supply damaged, and cause electric shock and fire.



As a long time, please put down the power cord from the wall socket

Otherwise cause the fire.

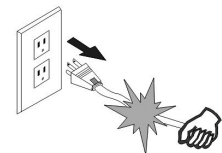


Machine running, don't put hands on axis, this will cause injury.



When the power cord from the socket, you should pull the plug, should not pull the cable.

Stronger pull the cable can result in electric shock or fire



Chapter 2 Handling and Installation

2-1 Crate handling

Use forklift with capacity of 1 tons to transport the crate.

2-2 Crate disassemble

Crate assembly

When packing, firstly put the bottom board. Then fix the machine's 4 wheels. After that, install the 4 side boards. Finally put on the top board.

Crate dis-assembly

Use the claw hammer to pull off the nails, the arrow direction was put the nails, you can take off the front cover and top cover.

2-3 Storage requirements

Storage temperature: 10-40 °C

Humidity: 30~90%

2-4 Machine handling

The machine transportation should be carried out by means of two persons. One person stands behind to push the machine and the other stands on machine front side to control the direction.

2-5 Space requirements

Length: 1.4m, Width: 1m, Height: 1.1m, you need a table for holder this machine the table size : 1.5(L)*1.2m(W)*0.6m(H).

2-6 Electric and pneumatic specification

Electric power: 220V, 50/60Hz as standard.

2-7 Installation procedure

1. Move machine to stable level floor by forklift.
2. Use wrench to adjust the level of machine foot.

Chapter 3 System introduction

3-1 Functions introduction

Mufti-function digital label die-cutter

VR-240 digital label die-cutter is developed for all kinds of applications. It can use for short work and big work, can die-cut all of shapes which you design, delivery time is very fast, it is your best partner for label printer. This machine collects laminate, die-cut, waste-remove, slit and rewind together, it is not only for die-cutting, but also working as one slitting machine. The operation is very easy, it applies into label, hang tag, and package widely, we believe that this machine will be applied more and more lines, You can discover the advantages by yourselves.

Suitable medias

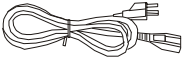
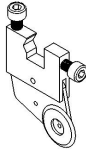


Adhesive label, PP, Plastic film, PET, PVC, white card paper, art paper and other soft media.

Example of application

Adhesive label, hang tag, paper box making, wine labels and etc.

3-2 Packing list

Once open the carton, please check following items, if there is something missed, please contact the local distributor or the manufacturer.

| No. | Item | Qty | Picture |
|-----|-----------------|-----|--|
| 1 | Power plug wire | 1 |  |
| 2 | Slitting unit | 4 |  |
| 3 | Blades holder | 2 |  |
| 4 | Blades | 5 |  |

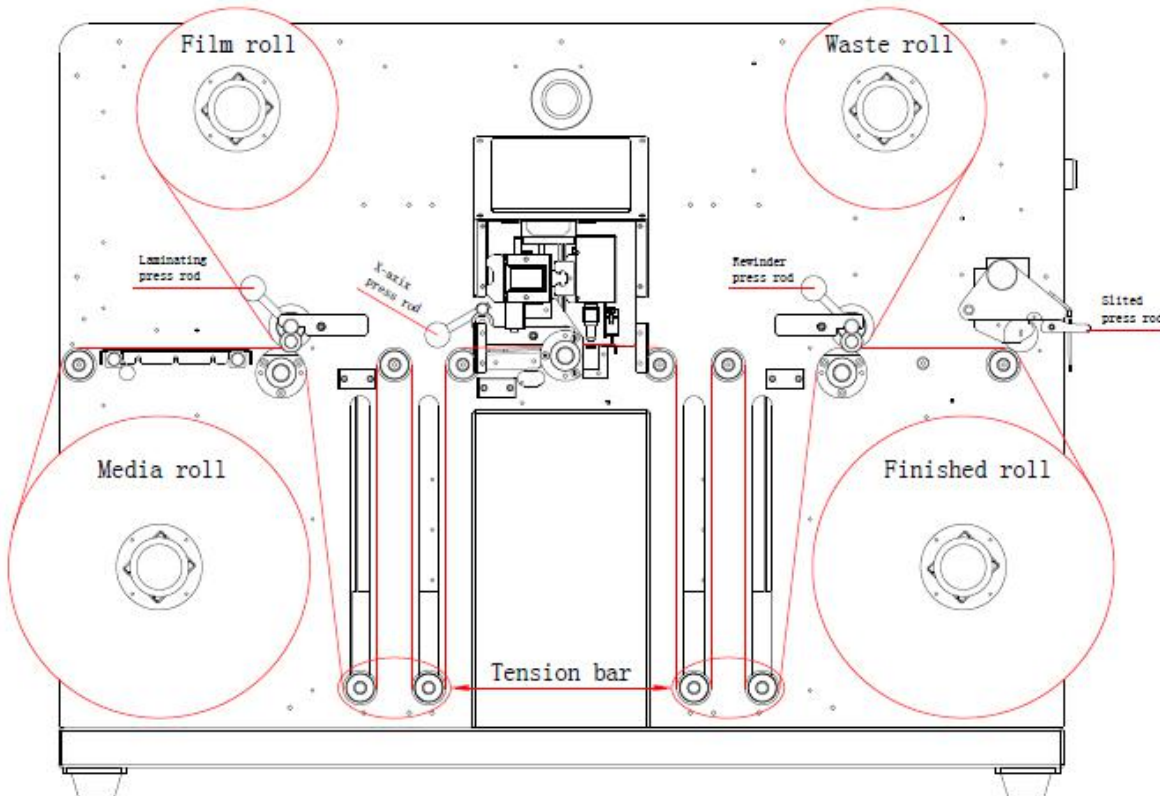
3-3 Specification

| | |
|------------------------|---|
| Machine model | VR240 digital label die-cutter |
| Max. media roller | Diameter 290mm |
| Cutting media width | 80-240MM |
| Max. cutting width | 230MM |
| Min. label length | 10MM |
| Max. label length | 300MM |
| Cutting speed | 8m per minute (depends on label shape and size) |
| Cutting blades | 2pcs |
| Die-cutting technology | Tungsten steel rotary blades |
| Cutting Precision | 0.1MM (Duplicate) |
| Cutting tracking | single eye mark or double eye mark |
| Slitting precision | 0.2MM |
| Slitting width | 10-240MM |
| Machine size | 91cm(W)x63cm(D)x74cm(H) |
| Weight | Approx. 120KG |
| Power | 100-240VAC, 1000 watts |
| Warranty | 1 year (except consumables parts) |

Chapter 4 Preparation Work

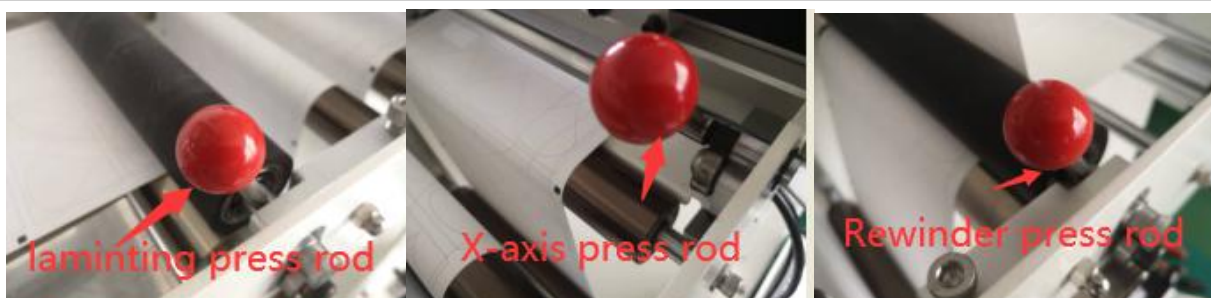
4-1 Media loading

4-1-1 Media installation flow chart P4-1-1, Media from media roll.



< P4-1-1 >

Please refer to the above media installation flowchart. Please install the material in the direction of the red line: first put the media on the unwinder, manually tension the expand shaft, and open the laminating rubber roller by laminating press rod P4-1-2. Manually thread the paper under the laminating rubber roll, bypass the tension bar, open the X-axis press rod, bypass the tension bar again, and open the rewinder press rod, Pass the material through the rewinding rubber roll, open the slitting press rod, pass the slitting shaft to the reel, tension the rewinding shaft, and press down all the press rods.



<P4-1-2>.

Notice: 1. There are same expand shaft for unwinder, lamination, waste removal, rewinder. The using method is same : Before load media, rotate black handle anticlockwise, the core diameter will be smaller; After load media, rotate black handle clockwise, the core diameter will be bigger.

2. Tensions of expand shaft are adjusted by tension break which are in the rear of machine, please open the machine door, you can see all tension break. Refer P4-1-3



<P4-1-3>.

4-1-2 Media from a printer



<P4-1-4>.



<P4-1-5>.

Please use data wire to connect machine and printer (At this moment, our machine can connect VIP color printer, VP700 inkjet printer, VP600 inkjet printer and VP750 inkjet printer, the print engine is from memjet.), please refer P4-1-4.

Please connect sensor fixed shaft on the machine base, please refer P4-1-5.



<P4-1-6>.

For the paper output direction of the printer, please refer to the paper feeding direction of the VR240 unwinder, and then follow the media loading way as in P4-1-6 Media from unwinder.

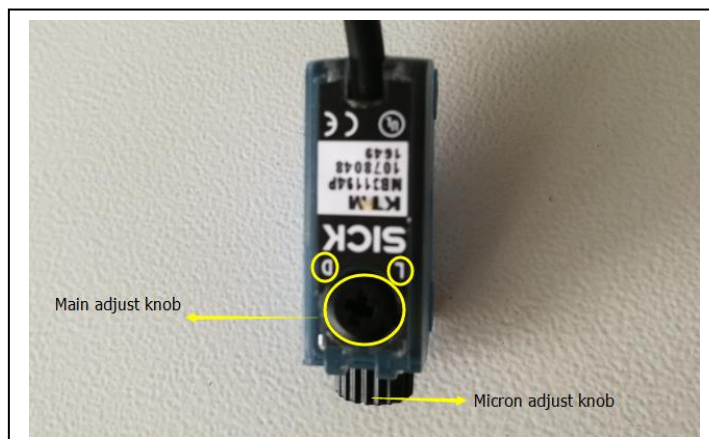
4-2 Sensor setup

4-1-1 Sensitivity adjustment refer P4-2-1

(1) Background is light color, and eyemark is dark. Please use cross screw driver to adjust knob clockwise to L position.

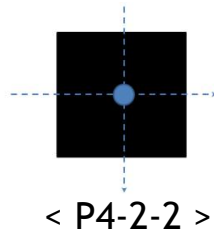
(Manufacturer default is L, don't change it)

(2) Background is dark color, and eyemark is light. Please use cross screw driver to adjust knob anticlockwise to D position.



<P4-2-1>.

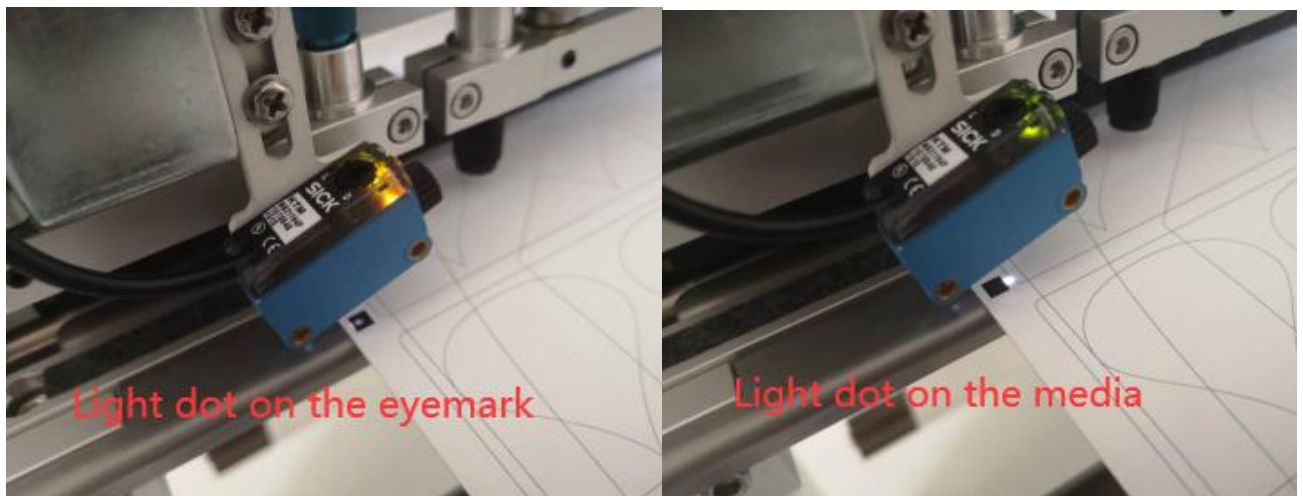
Move the sensor to place its light spot at the center of the black mark. Usually we use a black mark with a size of 4 mm * 4 mm, as shown in picture <P4-2-2>.



< P4-2-2 >

When installing materials, make sure that the sensor is installed properly, and the sensitivity of the sensor may need to be adjusted according to the material being die-cut. Make sure that the indicator light is on when the sensor is illuminated in a blank place, and the indicator light is off when illuminated on the black mark refer P4-2-3.

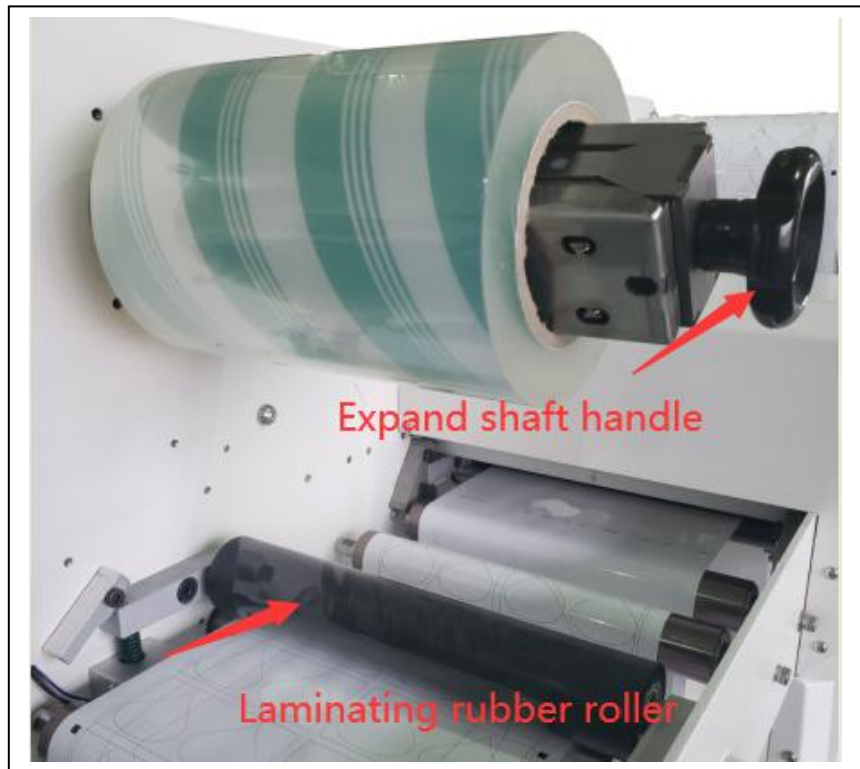
When loading the media, make sure that the sensor is installed properly, and the sensitivity of the sensor may need to be adjusted according to the material being die-cut. Make sure that the indicator light is on when the sensor is illuminated in a blank place, and the indicator light is off when illuminated on the black mark.



< P4-2-3>

4-3 Lamination setup


Load a laminating film roll on the laminating expand shaft, adjust the right position to cover exact area to laminate on the media and fix the core by expand shaft handle<P4-3-1>.



<P4-3-1>

Laminating expand shaft does not have driving motor connected. It is passive system using main feeding power.

There is tension break on back side of the laminating roller. You can see it and adjust the tension by rotating the knob inside of the right door, which controls spring power to increase/decrease the friction.

After loading laminating film, release the end and attach on the media before the laminating rubber roller. Use feeding button  to feed the media and laminating film going through the rubber roller on to the flat bed enough in stable way.

 **Caution: The width of laminating film must be less than the media's.**

4-4 Cutter unit setup

⚠ Caution: Please be careful not to touch cutting knives with bare hand.
They are very sharp.

Please wear PPE gloves before installation of cutting knives.

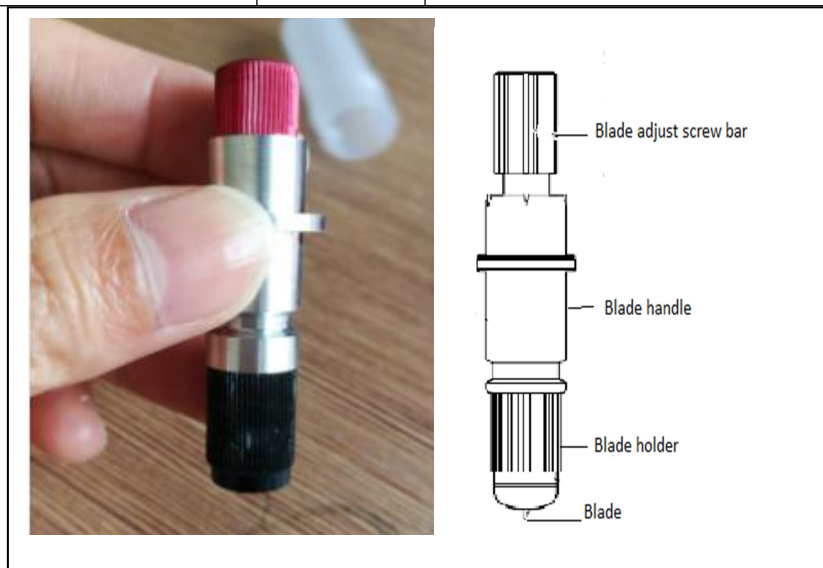
When we deliver the machine we already setup the cutting units with enough testing. Please follow below explanation when you replace cutting knife or replace / add cutting units.

4-4-1 Cutter unit assembly

Cutting unit is composed with several parts as shown in picture P4-4-1, including knife(blade), blade pouch, blade spring, blade adjust screw bar, bar spring and blade handle. The structure of cutter unit is very simple but very efficient. Blade spring gives constant pressure and blade adjust screw bar controls depth to cut. Cutter is equipped with cutting units as default .

How to choose the tool?

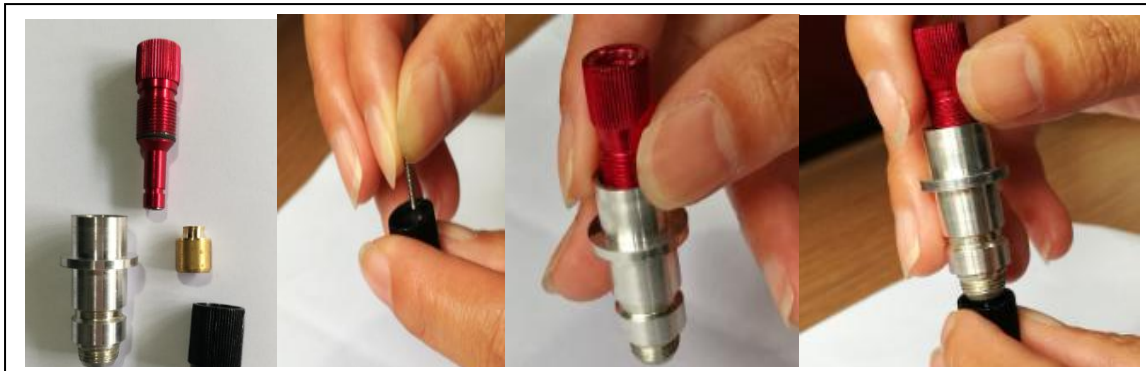
| Parts No. | Spec. | blade | For media |
|-----------|--------------|-------|--|
| 09U | ø0.9 mm 0.45 | 09U | Use for the media thickness is ≤ 0.25 mm . Can cut the media length is around 4000m |
| 15U | ø1.5mm 0.75 | 15U | Use for the media thickness is 0.25 mm to 0.5mm. |



<P4-4-1>

P4-4-2 is showing step by step process of how to assemble cutting unit in sequence. Disassembling can be done in reverse steps. This process is very simple and frequently used for blade replacement. The lifetime of blade can be 50 hours of continuous operation depending on the working condition (about 1,400 meters life time in case of art paper labels).

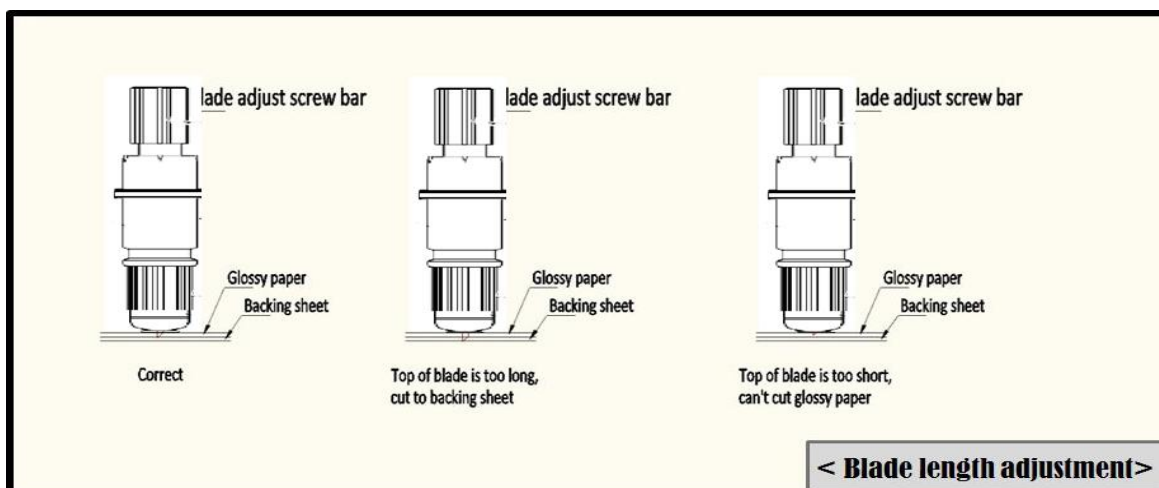
There are many small parts composing the cutting unit, so be cautious not to have missing parts during assembling or disassembling the cutting unit.



<P4-4-2>

4-4-2 Adjust the knife depth

It is possible to adjust the depth of cutting knife by rotating the Blade Adjust Screw Bar. Different media has different thickness for half cut and full cut, so find optimum depth to cut properly without scratching on the back liner. See illustration in Picture P4-4-3 and P4-4-4 as following.



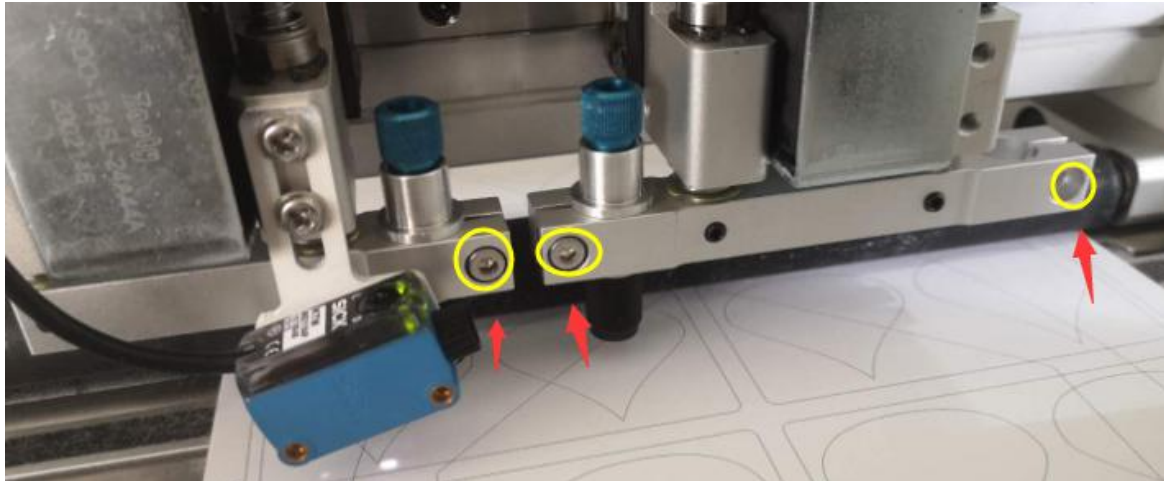
< P4-4-3 >



< P4-4-4 >

4-4-3 Assembling Cutting knife unit with Cutting head

Put the Cutting knife unit into the knife unit holder of each cutting head. And manually rotate the screw bolt (yellow circle) to fasten the cutting knife unit rigidly. Refer to P4-4-5.



< P4-4-5>

4-5 Waster removal setup

The independent motor controls the waste discharge shaft, peel off the waste from the media as shown in P4-5-1, fix it on the waste discharge shaft, and tighten the expand shaft handle and fix the core of waste roll. Press the switch of waste motor P4-5-2. Please adjust right tension break of waste expand shaft, in order to avoid any tensile failure.



< P4-5-1>

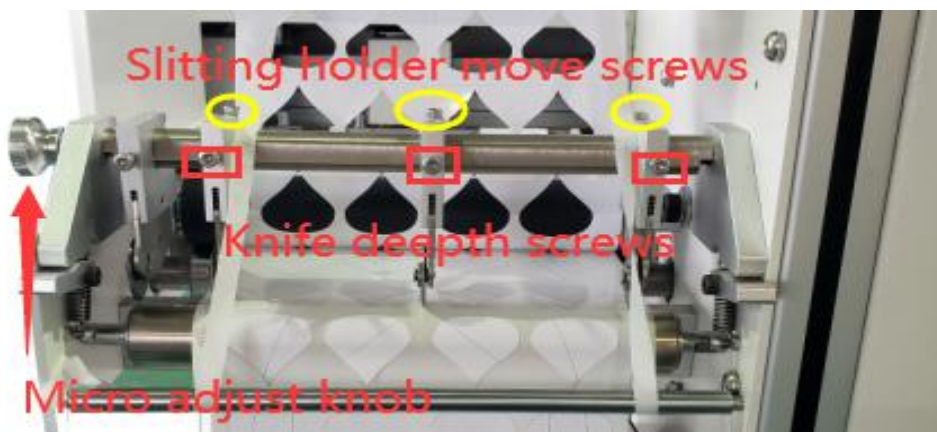


< P4-5-2>

4-6 Slitting unit setup

Slitting unit installation and adjustment

The slitting holder has 2 screws as shown in the P4-6-1. Loosen the screw bar and move the slitting holder to the position where the blade is to be placed. The standard machine has 4 slitting holders, the maximum of 8 slitting holders can be installed, and the depth of the cutting knife can be adjusted by tightening or loosening the bars.



< P4-6-1 >

The bar on the front of the slitting knife is used to micro adjust knob the position of the slitting knife. Turning the bar can make the slitting knife move as a whole (the distance between the slitting knives cannot be adjusted), and the adjustable range is 10mm.

⚠ Note: The slitting knife is sharp. Be careful when installing it to avoid cutting your fingers.

The position of the slitting rod can be moved P4-6-2. Usually when using a square knife, we choose (A) to cut in the air, and when using a round knife, we choose (B) to cut on the drive rod. When the material bottom paper is paper, it is recommended to use method (B) to effectively reduce paper dust. As shown below.



< P4-6-2 >

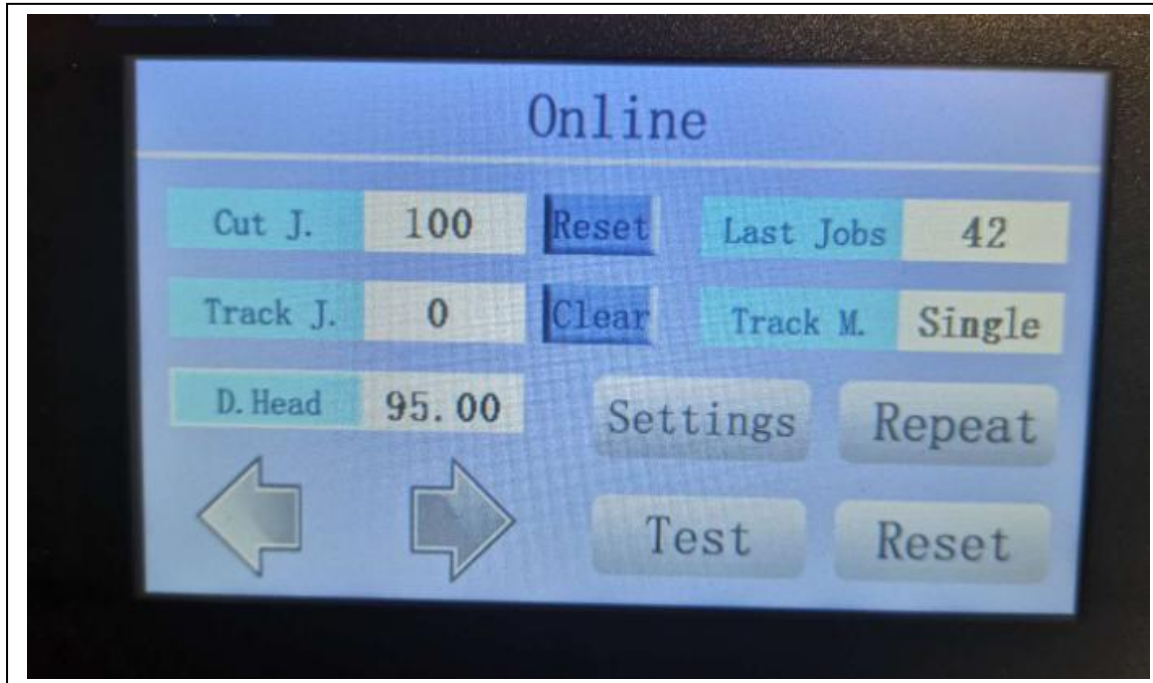
4-7 Rewinder setup

If you use the slitting function, you need to prepare some empty paper tubes with the same size as the slitting width, and place them on the rewinding expand shaft, and manually set the tension of the rewinder refer to P4-1-3.

Chapter 5 System Operating Instruction

5-1 Operation instruction of control panel

5-1-1 Panel button instruction, the main panel is in the front of machine P5-1-1.



< P5-1-1>

Emergency stop button: All motors stop working, only the system works P5-1-2.

Power button: power on the machine in the left side of machine P5-1-3.

Ethernet port: Ethernet port is in the left side of machine P5-1-3.

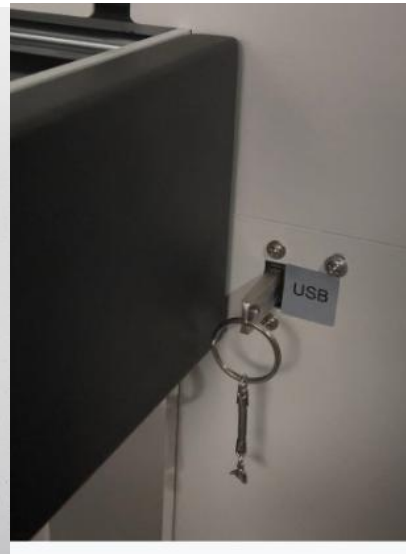
USB port: It is right side of panel board P5-1-4.



< P5-1-2>



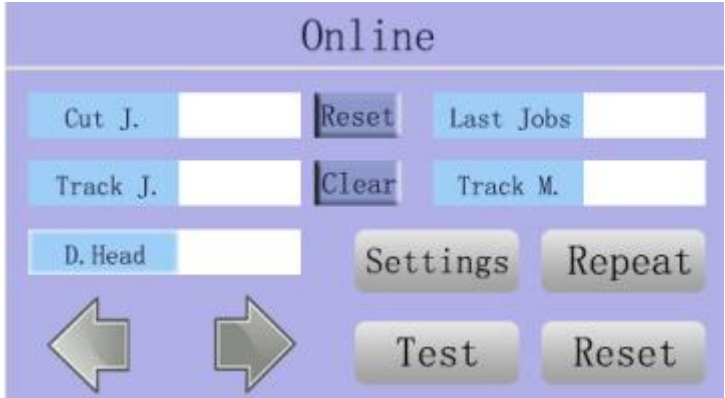


< P5-1-3>

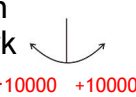
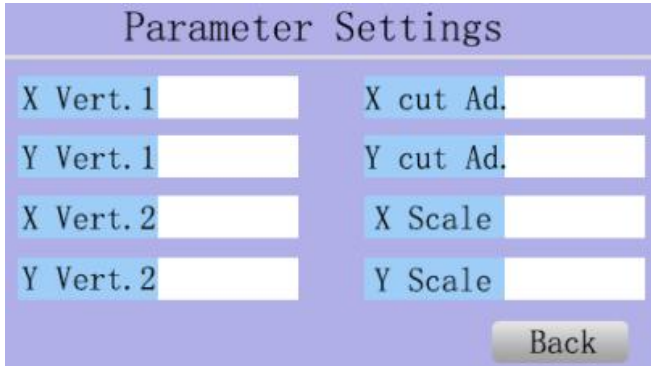
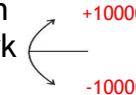
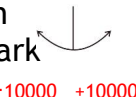
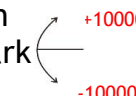

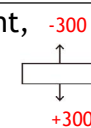
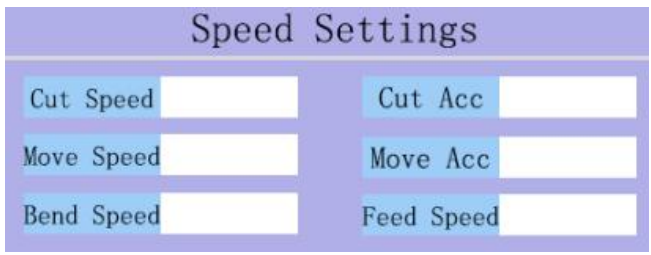


< P5-1-3>

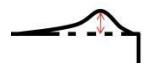


5-1-2 Function instruction

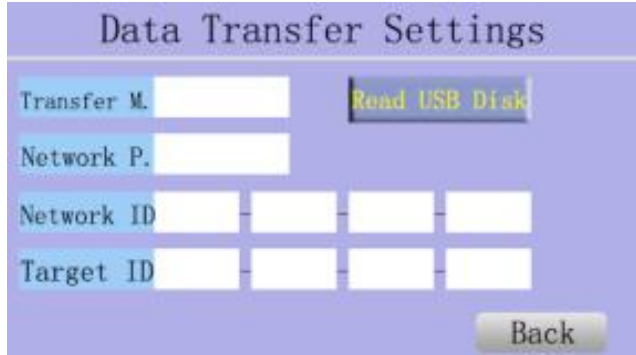

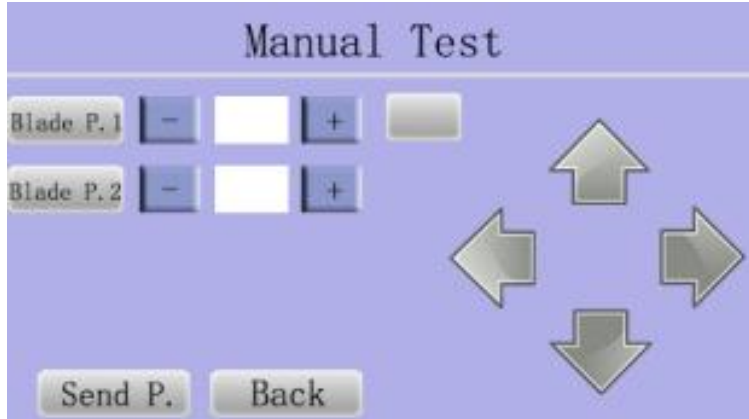
Turn on the computer and tap the screen to enter the main program, and tap the value display area to change the value.

| No. | Parameter | Value | Instructions | Screen Picture |
|-----|---|----------------------------------|---|--|
| 1 | Cut J. | 1~30000 | The quantity of each cutting job. |  |
| | Track J. | 0~30000 | The quantity of the printing jobs between twice tracking marks. | |
| | Last Jobs | 1~30000 | The quantity of the last cutting job | |
| | Track M. | No Mark, Single M. and Double M. | The way of tracking marks | |
| | D. Head | | The distance between 2 heads | |
| | Settings | | Machine settings (refer to No.2) | |
| | Repeat | | Repeat the last cutting job. Invalid after reboot | |
| | Test | | | |
| | Reset | | Press it after each cutting job | |
| |  | | Control the media movement manually. | |
| 2 | Parameter | | Adjust the cutting position and size (refer to No.3) |  |
| | Tools | | The setting for general tools (refer to No.5) | |
| | Factory Reset | | To default values | |
| | Speed | | Adjust the cutting speed (refer to No.4) | |
| | Data Trans | | Set transfer way and network port of the cutting file (refer to No.6) | |
| | Tools Select | On/Off | Turn on or off for every single head | |
| | Back | | Back to the previous menu | |

| No. | Para. | Value | Instructions | Screen Picture |
|-----|------------|--------------|--|---|
| 3 | X Vert. 1 | -10000~10000 | X1 Verticality: Adjust X direction verticality (angle) for single mark mode  |  |
| | Y Vert. 1 | -10000~10000 | Y1 Verticality: Adjust Y direction verticality (angle) for single mark mode  | |
| | X Vert. 2 | -10000~10000 | X2 Verticality: Adjust X direction verticality (angle) for double mark mode  | |
| | Y Vert. 2 | -10000~10000 | Y2 Verticality: Adjust Y direction verticality (angle) for double mark mode  | |
| | X Scale | -1~1 | For every 0.01 increase or decrease, the image in X direction will be enlarged or reduced by 1% | |
| | Y Scale | -1~1 | For every 0.01 increase or decrease, the image in Y direction will be enlarged or reduced by 1% | |
| | X Cut Ad. | -300~300 | Change X direction position movement, unit in mm, accurate to two decimal places  | |
| | Y Cut Ad. | -300~300 | Change Y direction position movement, unit in mm, accurate to two decimal places  | |
| 4 | Cut speed | 1~3000 | Setting the cutting speed |  |
| | Cut Acc. | 1~500 | Setting the acceleration of cutting speed | |
| | Move Speed | 1~3000 | Setting the moving speed between label and label without cutting | |
| | Move Acc. | 1~500 | Setting the acceleration of move speed | |
| | Bend speed | 0~100 | Setting the bend speed | |

| | | | | |
|--|------------|-------|---------------------------------|--|
| | Feed Speed | 1~100 | Setting the media feeding speed | (Note: Set the speed according to the graphics. When the circle and polygon are less than 20MM, the turning speed needs to be reduced) |
|--|------------|-------|---------------------------------|--|

| No. | Para. | Value | Instructions | Screen Picture |
|-----|----------------|-----------------|---|--|
| 5 | Cut Ad. | 0~100 | Change the top of blades moving radius. The unit is 0.025mm.  Note: when you use software set cut Ad, please disable it. |   |
| | Cut P. Ad. | | Adjustment when the value of D. Head (refer in No.1) is different with the real physical data. | |
| | Cut down time | 0~10000 | The time from command to knife down. The unit is ms. | |
| | Feed P. Ad | | The distance between two jobs | |
| | Down speed L. | 0~100 | Limit the acceleration and speed of small line segments, used for program debugging, users should not modify | |
| | Language | Chinese/English | Setting language | |
| | Online | On/Off | Online or offline with a printer | |
| | Mark Length | 0~100 | Unit is mm, mark length | |
| | Mark Width | 0~100 | Unit is mm, mark width | |
| | Track IO input | B/W | Black & White, setting of mark color | |
| | X length | 0~2000 | X axis travel range, no need to change | |
| | Y length | 0~265 | Y axis travel range, no need to change | |
| | Send P.R | | Service purpose, user don't change | |

| | | | | |
|---|---------------|---------------------|---|--|
| 6 | Transfer M. | NET/USB | Setting the mode of transfer |  |
| | Network P. | | Setting the network port | |
| | Network ID | | Setting the machine's IP address | |
| | Target ID | | Setting the connected computer's IP address | |
| | Read USB Disk | | Choose and read the file when in the mode of USB | |
| 7 | Cutter 1 | On/Off | On/off of the Cutter 1 |  |
| | Cutter 2 | On/Off | On/off of the Cutter 2 | |
| | | | | |
| 8 | Blade P. 1 | 400~1000 | The greater the setting value, the greater the knife pressure, unit: gram |  |
| | Blade P. 2 | 400~1000 | The greater the setting value, the greater the knife pressure, unit: gram | |
| | Moving speed | HS/LS | The moving speed when in manual test. | |
| | Direction | Up,down,left, right | The direction of movement. | |
| | Back | | Back to the previous menu. | |
| | | | Note: The knife pressure value does not represent the length of the knife tip. Before using the knife pressure setting, the thickness of the material to be cut should be adjusted to the same length as the knife tip. | |

5-2 Work flow diagram

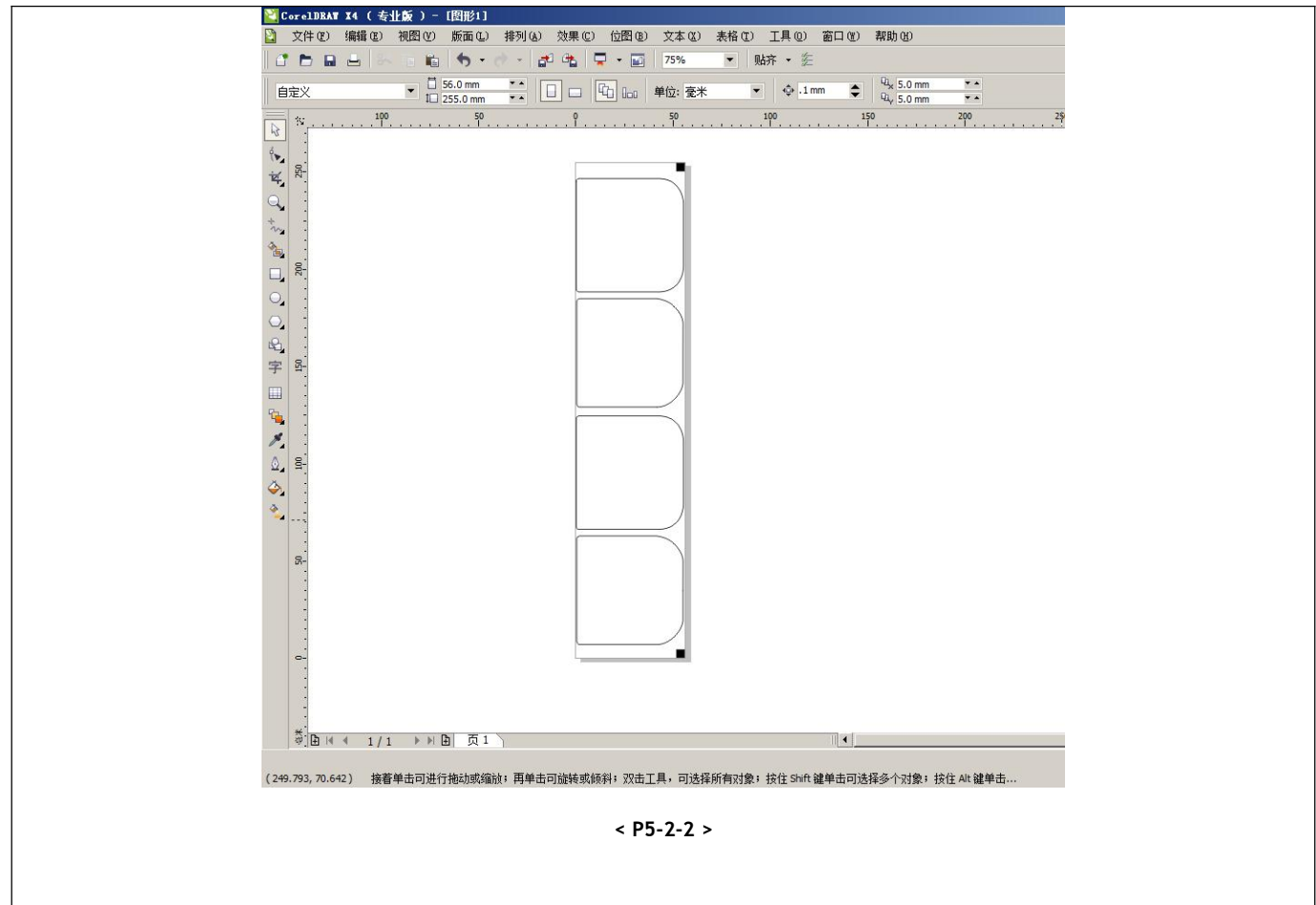
5-2-1 Requirements for cutting file

The size of the black mark is not less than 4*4mm, ensure that the black mark is 2mm away from the content and the black mark is parallel to the printed content, hide the die line, and export the printed file P5-2-1.

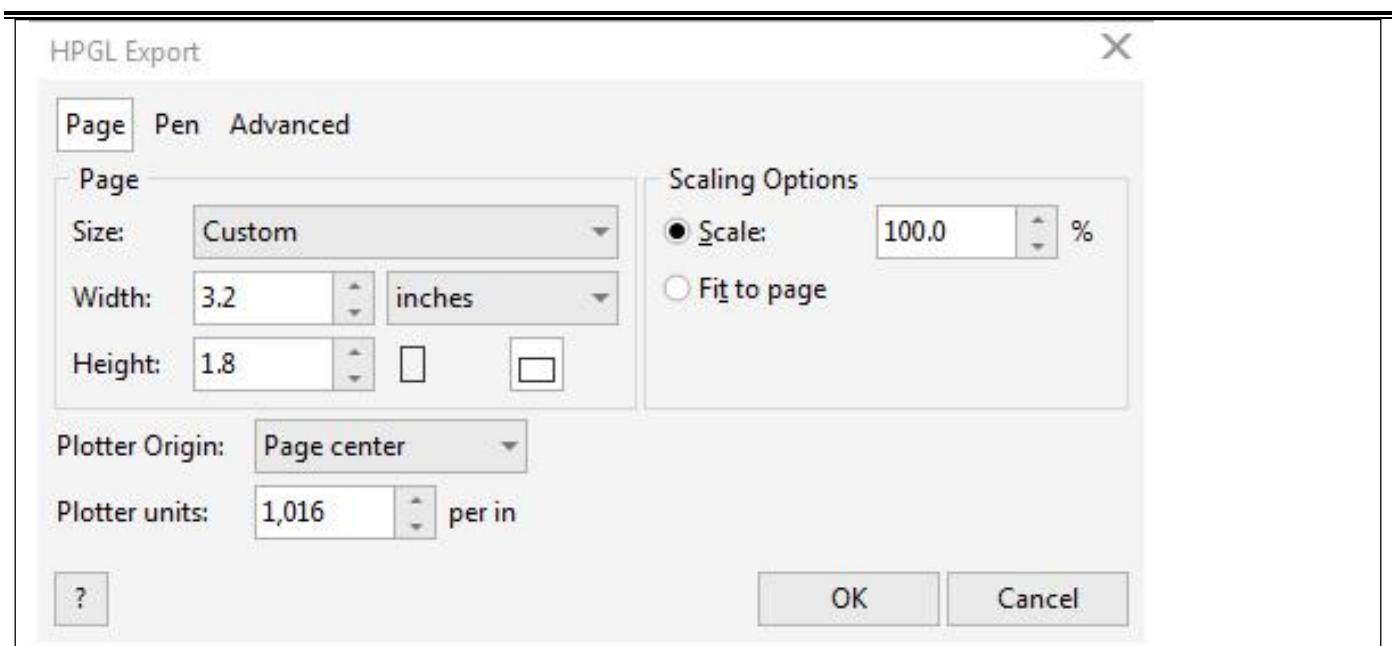


< P5-2-1 >

5-2-2 Requirements for cutting file



< P5-2-2 >



HPGL Export

Page Pen Advanced

Page

Size: Custom

Width: 3.2 inches

Height: 1.8

Plotter Origin: Page center

Plotter units: 1,016 per in

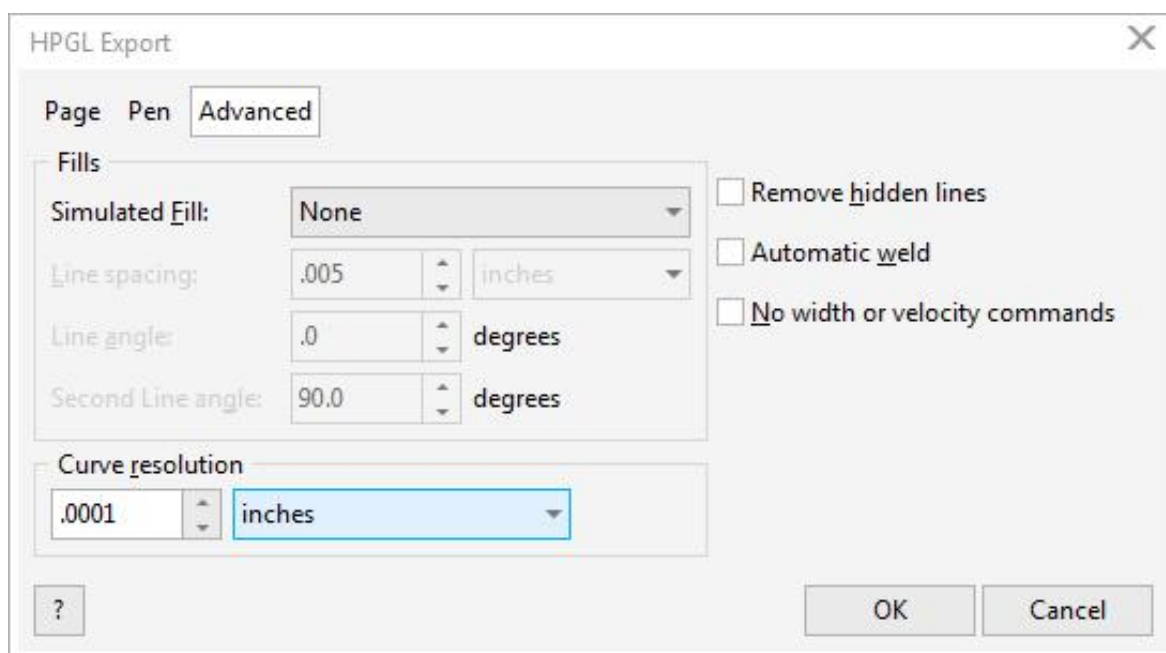
Scaling Options

☒ Scale: 100.0 %

☐ Fit to page

? OK Cancel

< P5-2-3 >



HPGL Export

Page Pen Advanced

Fills

Simulated Fill: None

Line spacing: .005 inches

Line angle: .0 degrees

Second Line angle: 90.0 degrees

Curve resolution

.0001 inches

☐ Remove hidden lines

☐ Automatic weld

☐ No width or velocity commands

? OK Cancel

< P5-2-4 >

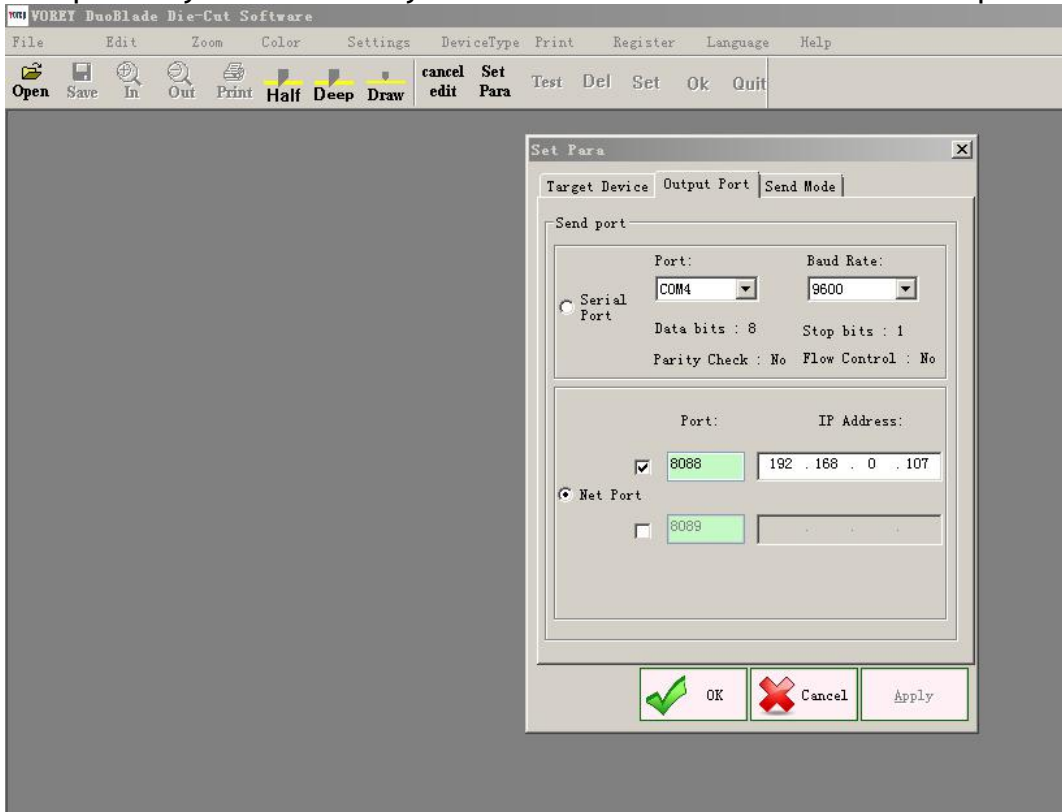
Export the die-cutting file to PLT format, the plotter unit is 1013, and the curve resolution should be 0. Refer to P5-2-3

Note: Regardless of whether you want to find single-label or double-label printed documents and die-cut files, they must be double black labels, and the double black labels must be on the right P5-2-4.

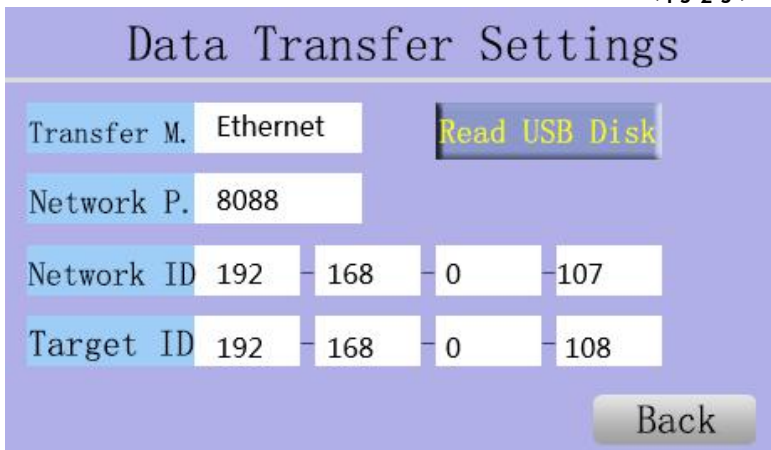
5-2-3 VR240 Cutting Software Setup

5-2-3-1

Click Settings>Set Para>Output Port, select the network port as shown in the Picture <P5-2-5> , enter the port number and the IP address in the same LAN as the PC. Note: The cutting software is safe and does not need to be installed, but it must be placed under other disks except the system disk and you can send the shortcut to the desktop.



< P5-2-5 >

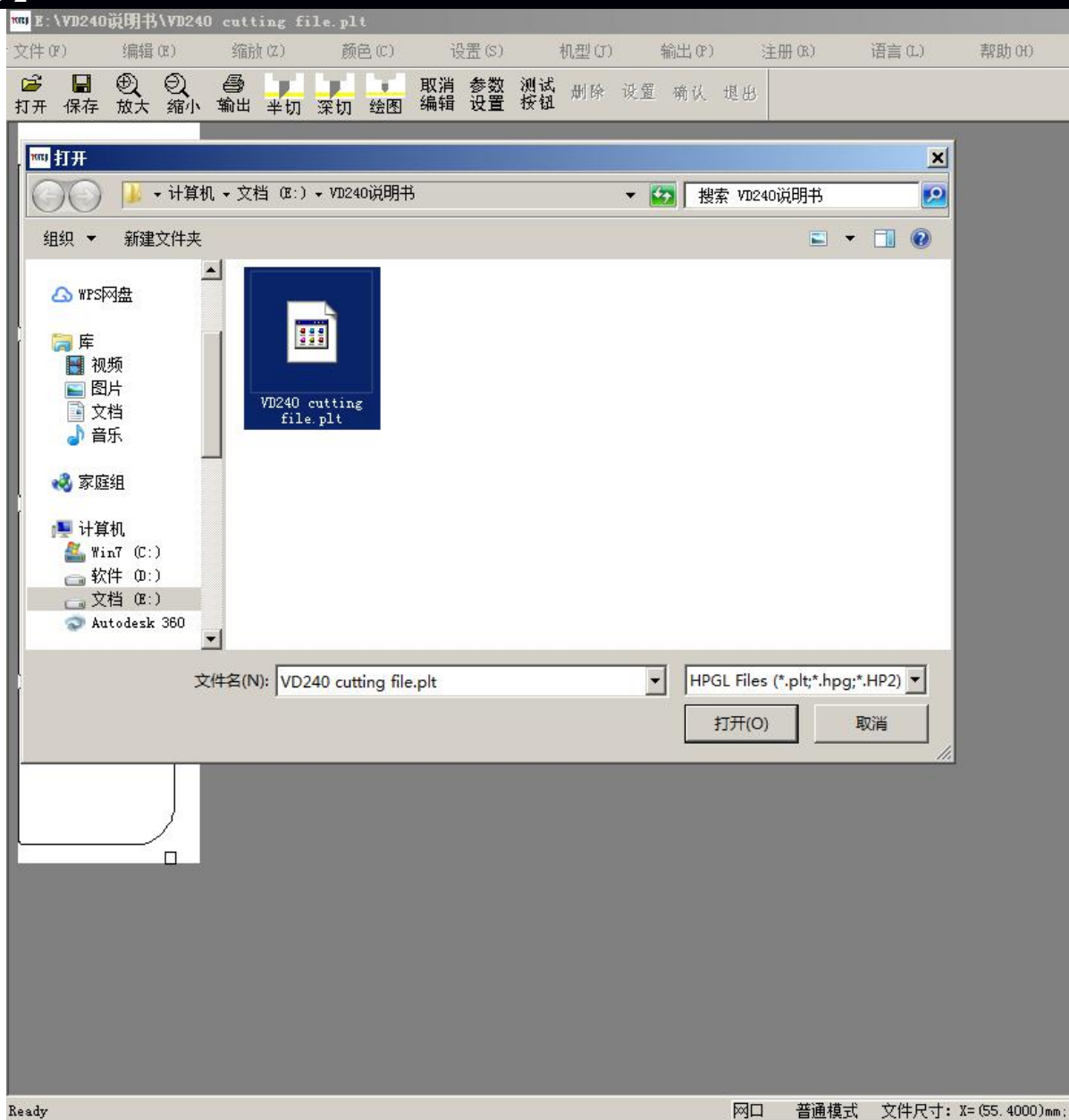


< P5-2-6>

In the Data Transfer item in the machine screen control system, select the Transfer Mode: Network, input network port and network address. Set the port and IP address you set same as in the software before. The target address sets the IP address of the PC on the software refer to P5-2-6.

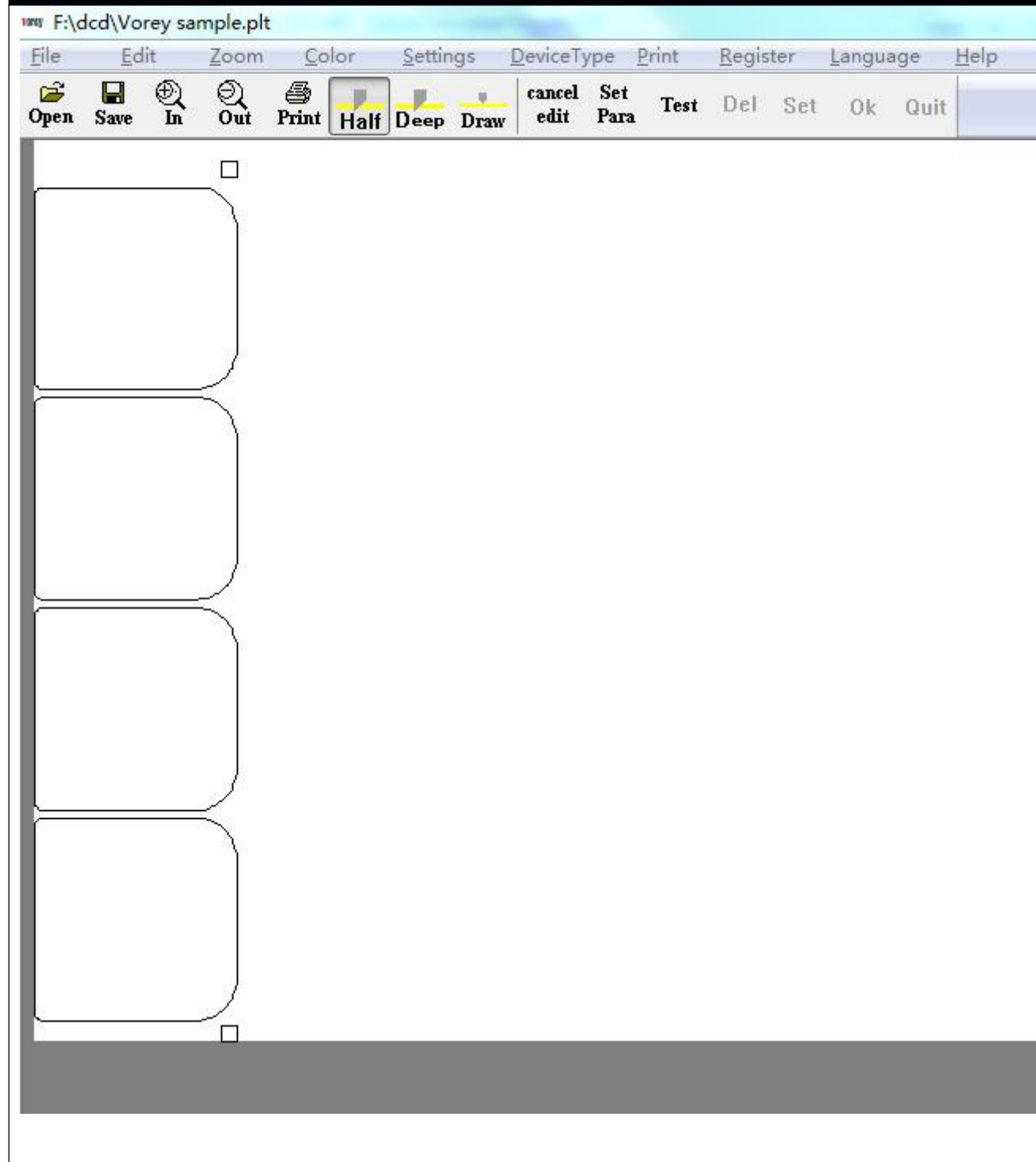
Cutting file's sending and setup

5-2-3-2

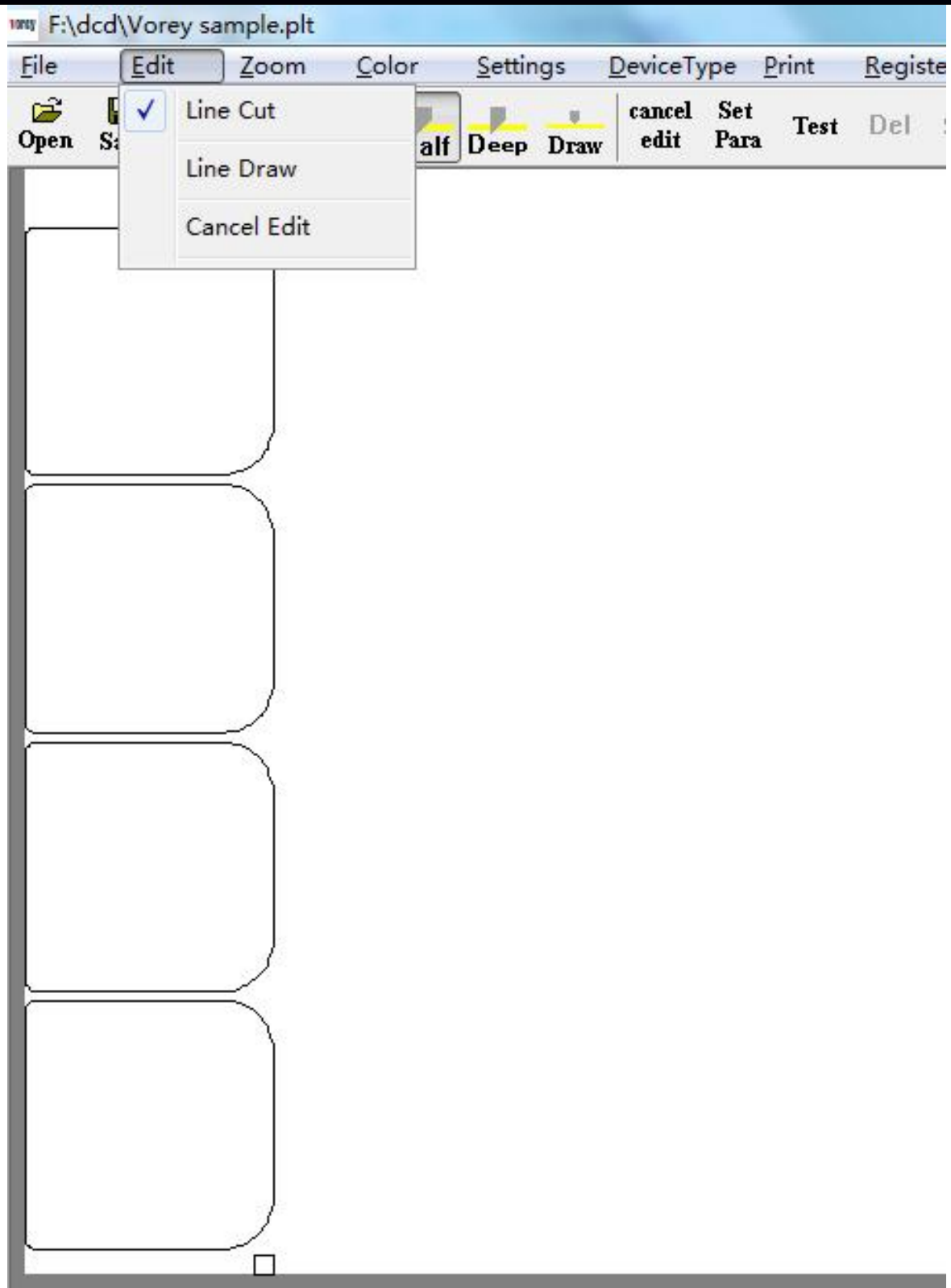


Open the cutting software, then open a .plt file.

5-2-3-3

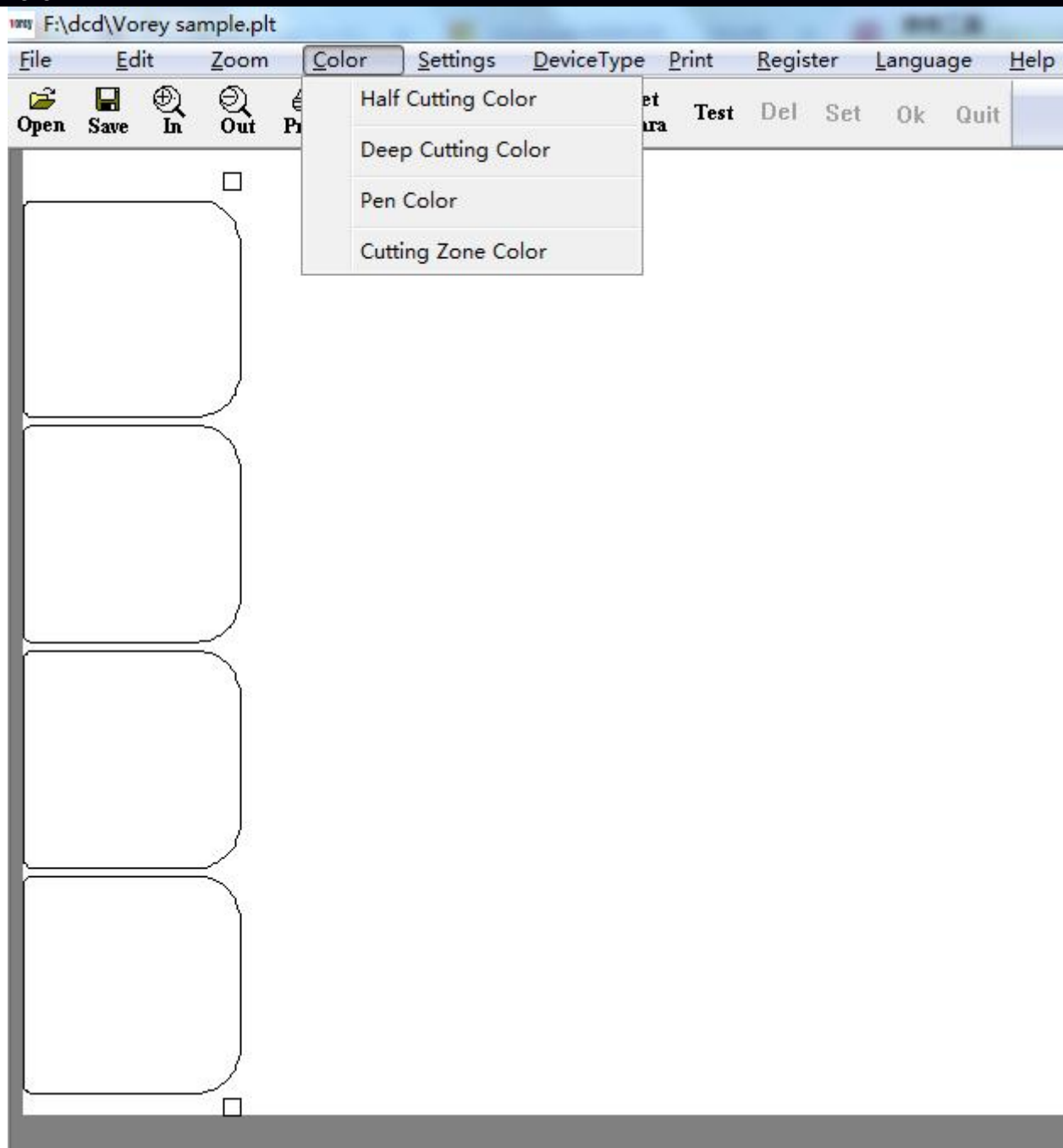


5-2-3-4



In the toolbar, Edit function covers edit and delete. Line cut means choose the cutting line you need; Line draw means choose the black marks; Cancel edit means cancel what you've done.

5-2-3-5

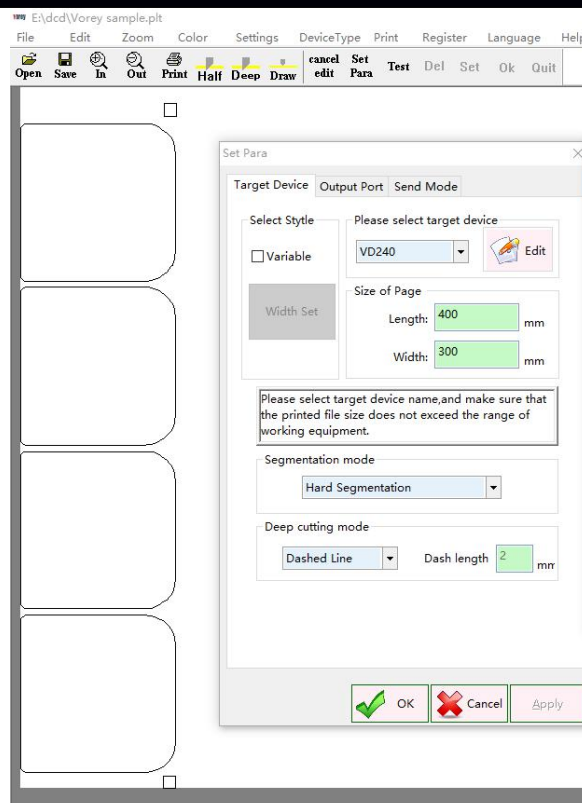




Color selection: Knives and pens can be customized according to customary display colors.

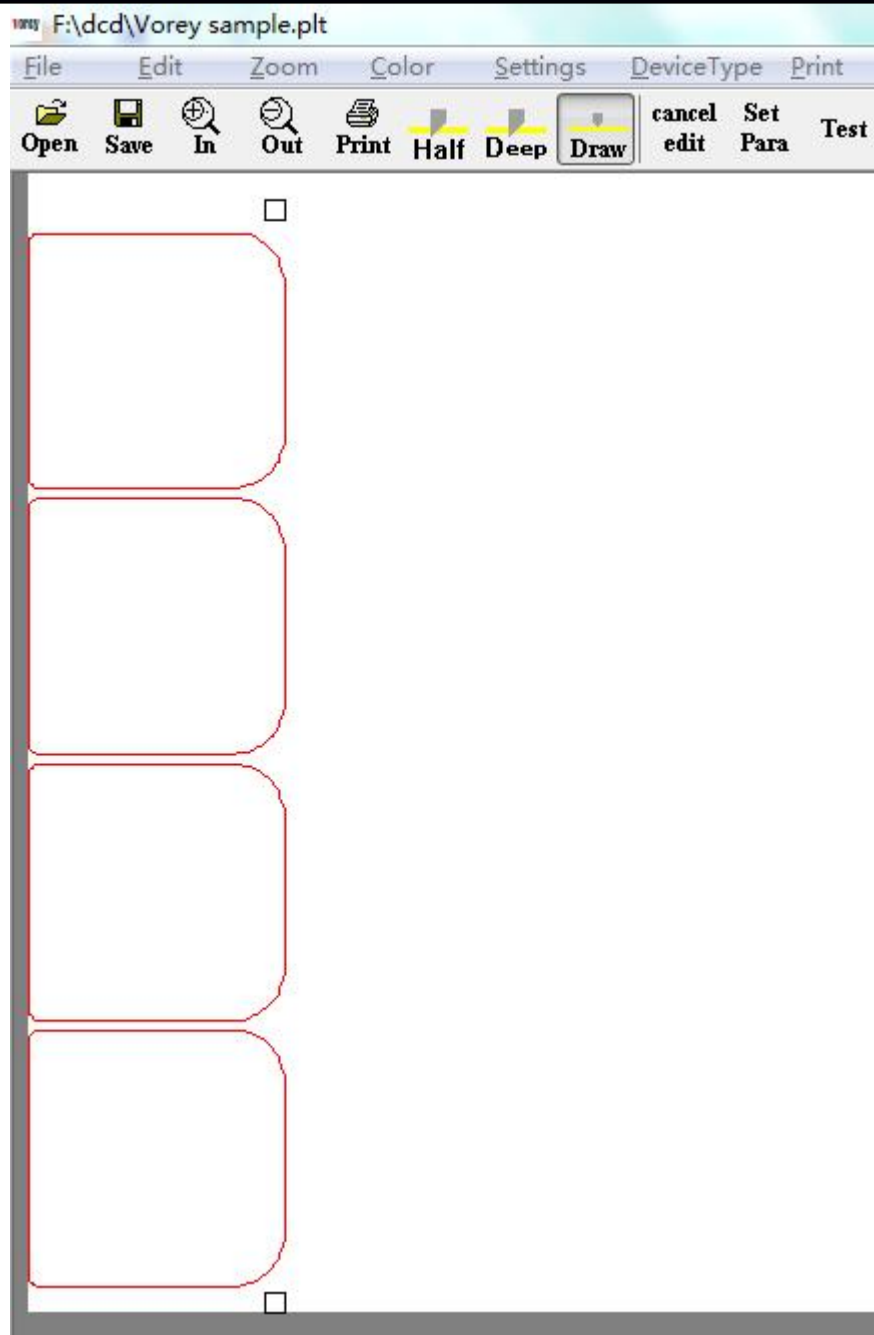
Default color: the color of the knife is red, the color of the pen is black, and the color of the cutting area is white.

5-2-3-6



The parameter setting window has 3 tabs. Click the "Target Device" tab, you can see that VD-240, page size 400mm×300mm by default. Select hard segmentation.

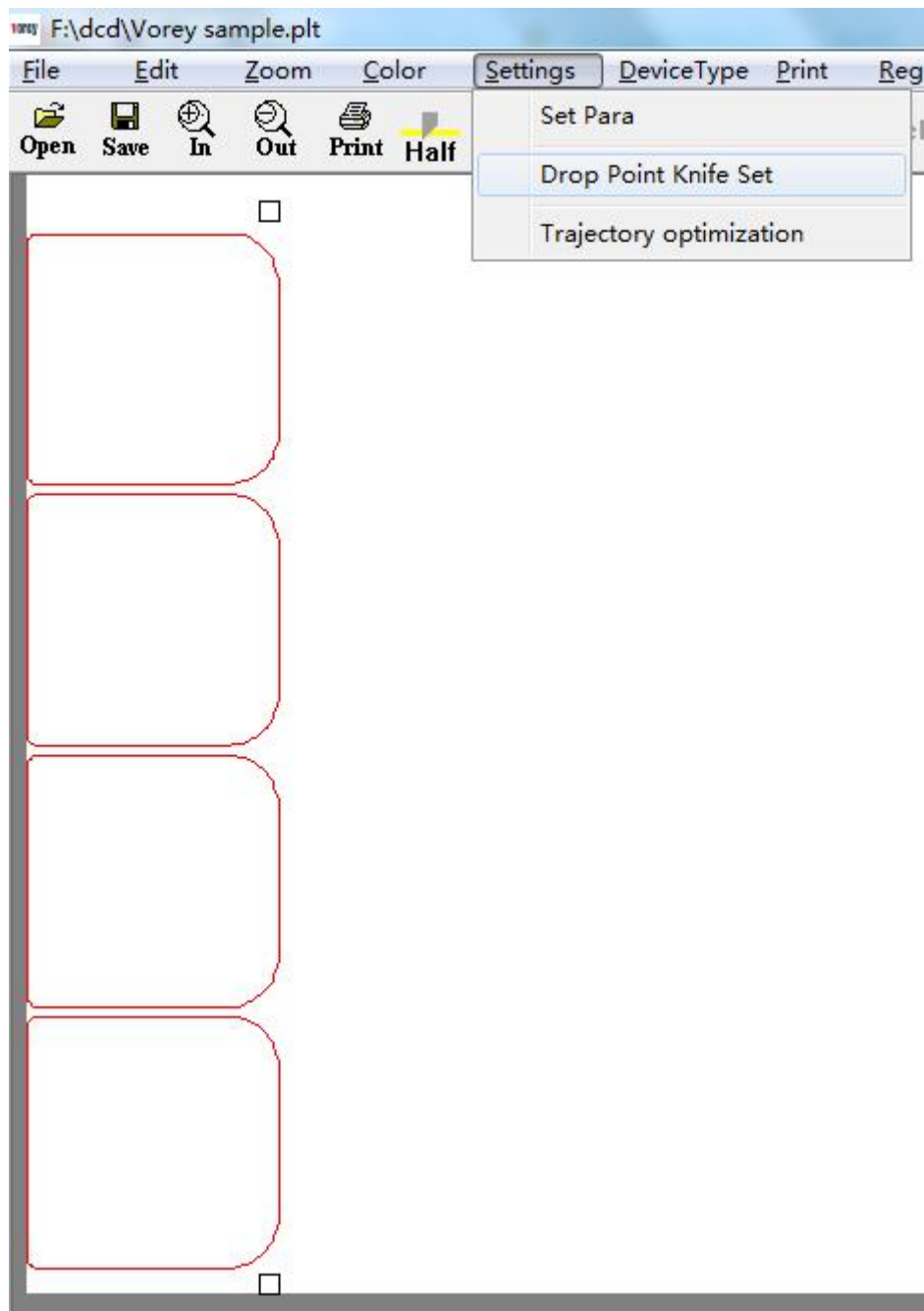
5-2-3-7



Click the half-cut icon and select the graphics to be die-cut. Do not select the black mark.

Note: The default layout is the drawing setting option.

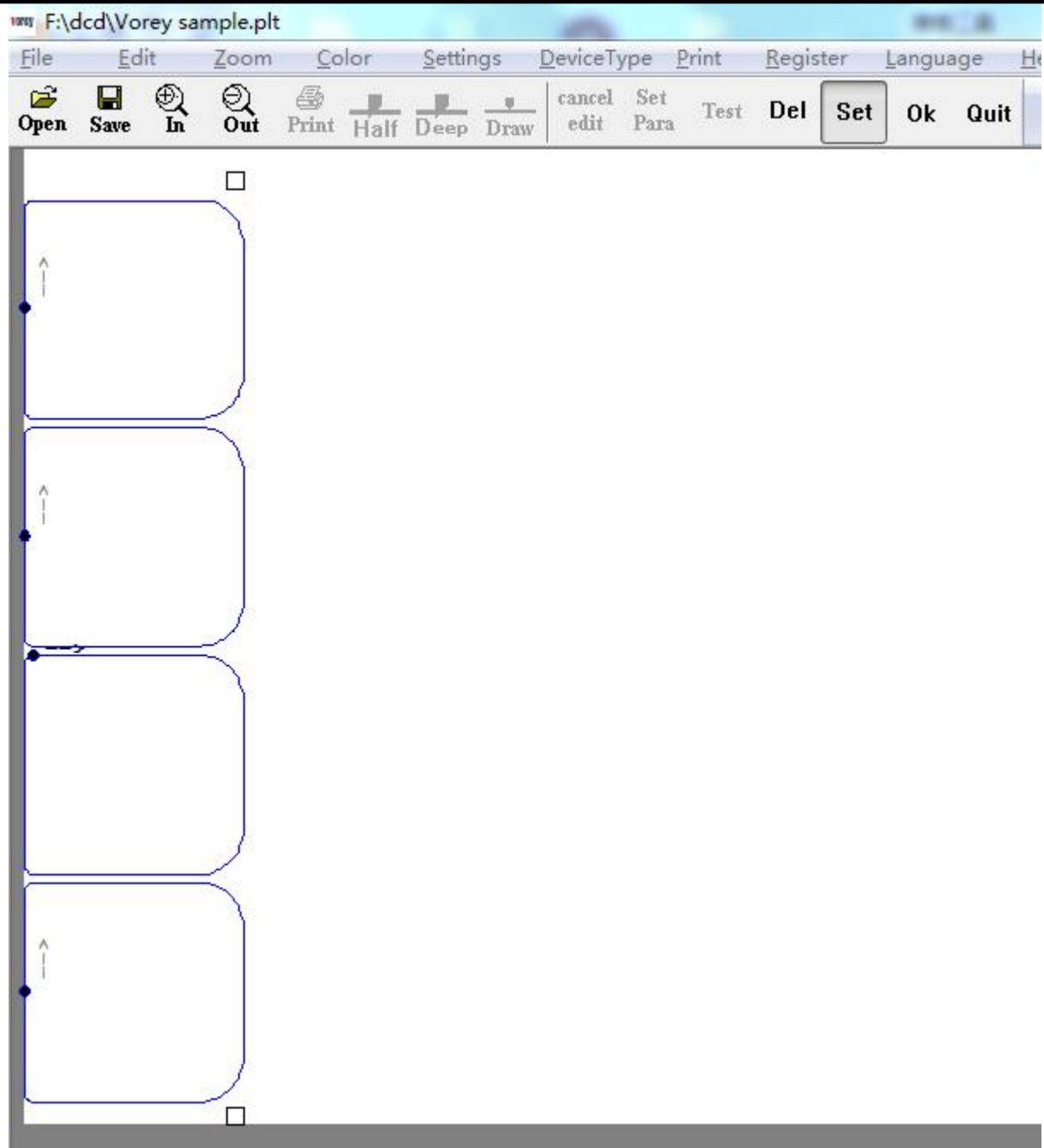
5-2-3-8



Click Settings-Drop Point Knife Set option to change the starting position of the knife drop.

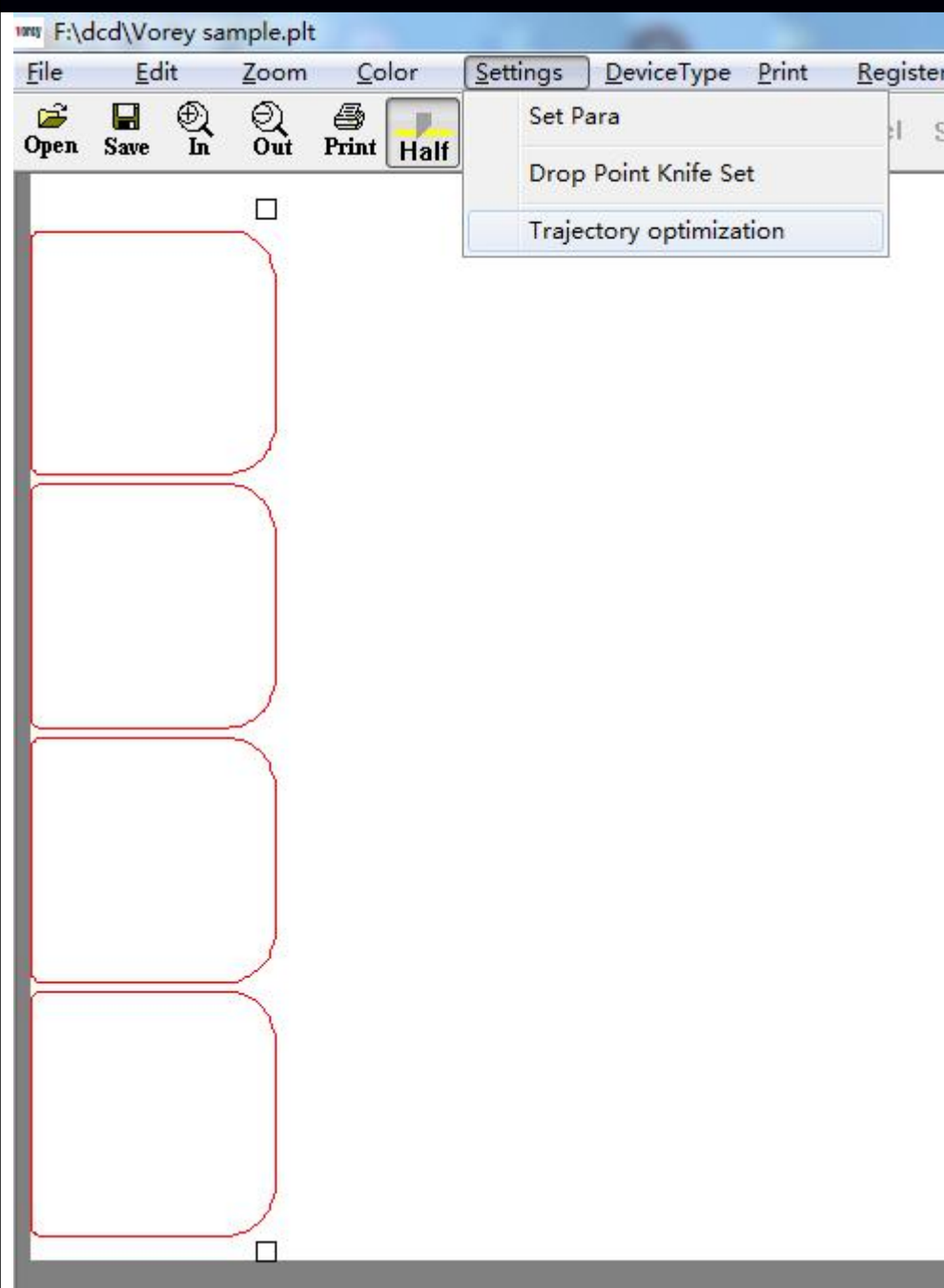
Note: The setting of the knife drop position depends on whether the cutting direction of the knife needs to be changed.

5-2-3-9



Left-click the position of the knife you want to set with the mouse arrow, and click the OK button to confirm. Click Del to delete the setting.

5-2-3-10

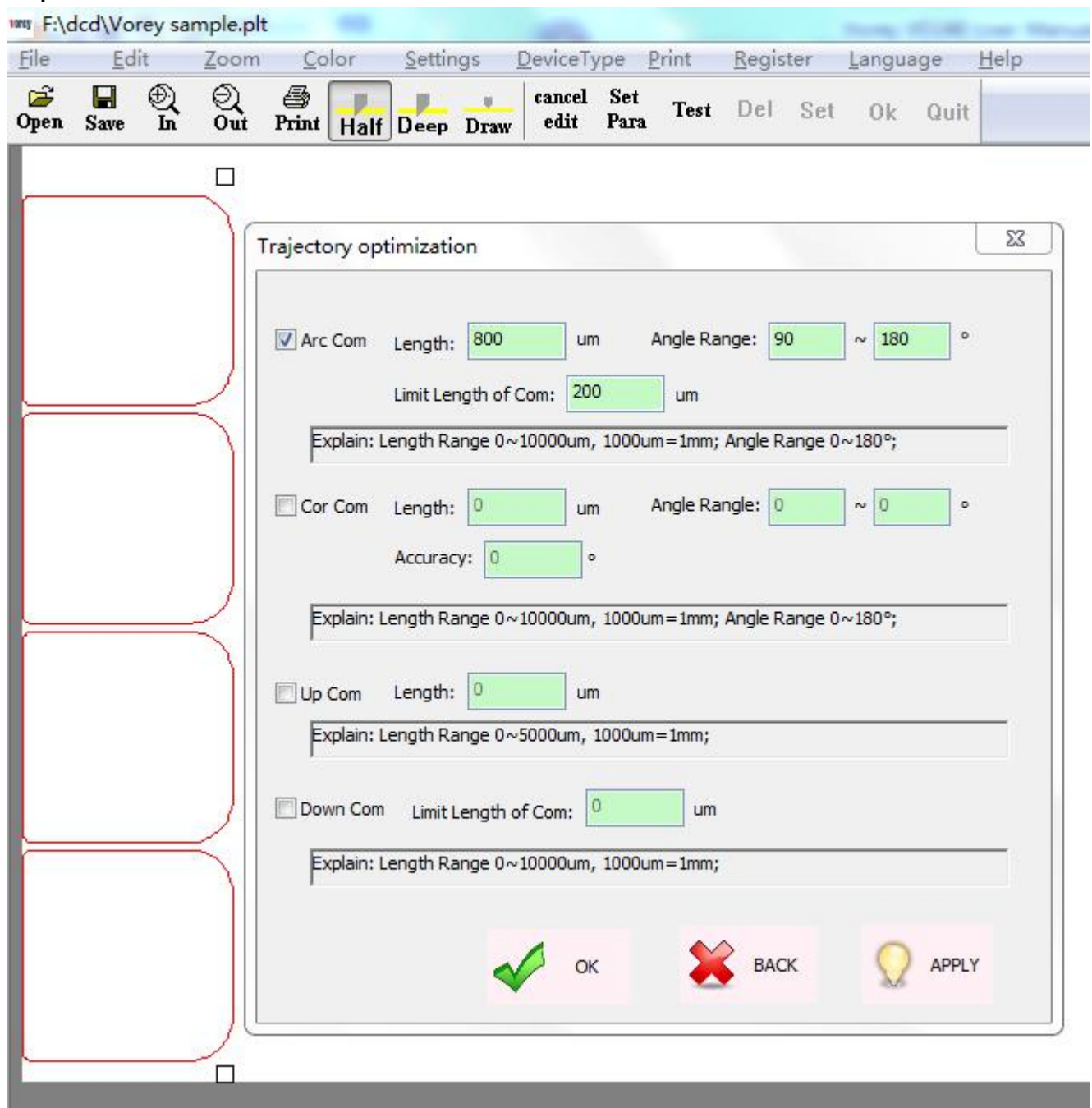




Open the cutting software, click Settings, and select Trajectory optimization.

5-2-3-11

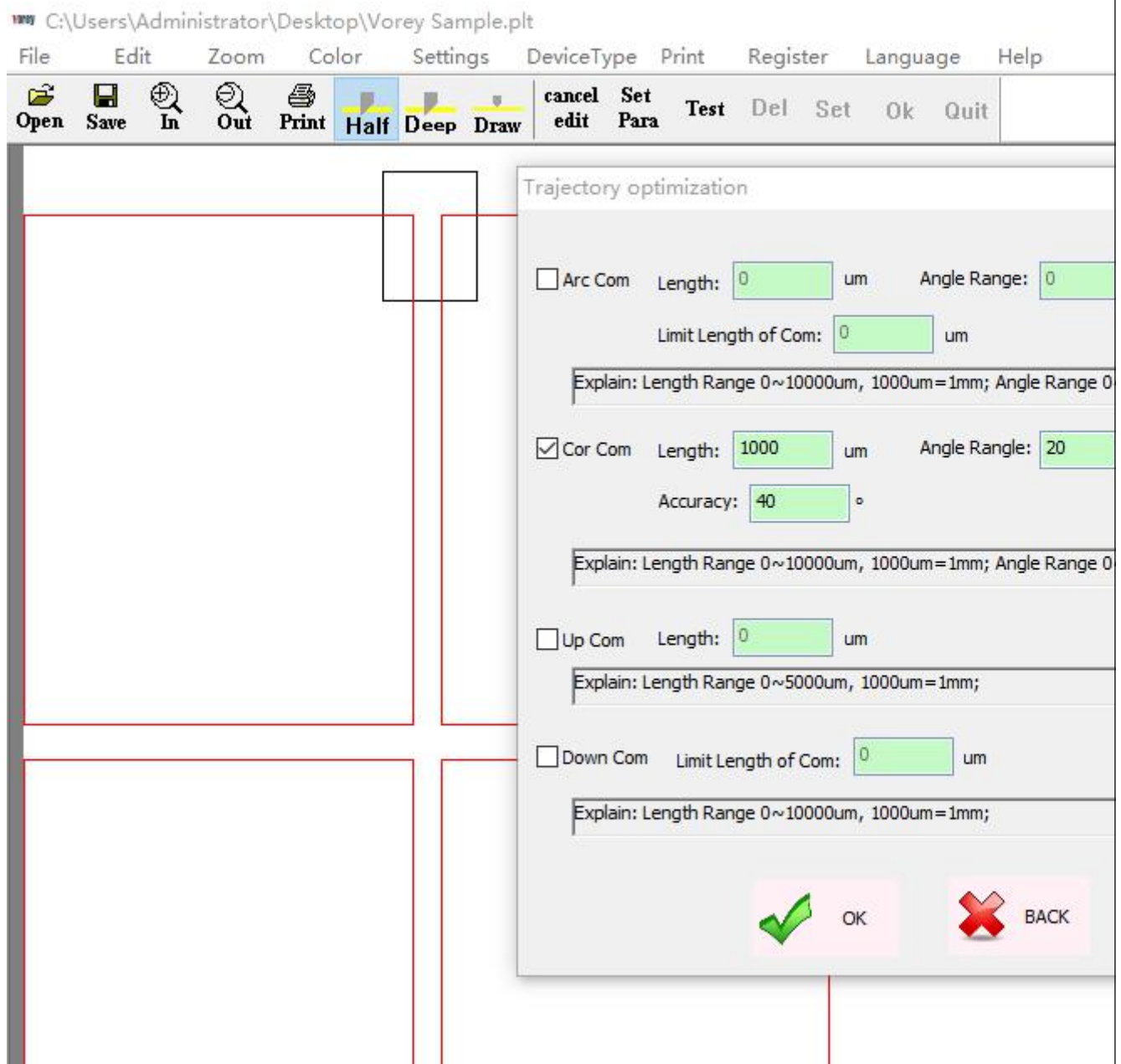
As shown in the figure:



when the label is rounded corners, the turning radius cutter compensation is required.



Note: The principle of this turning radius compensation is the same as the turning radius compensation in the machine setting. To use it in the software, you need to turn off the turning radius compensation in the machine setting and first click  APPLY then click  OK

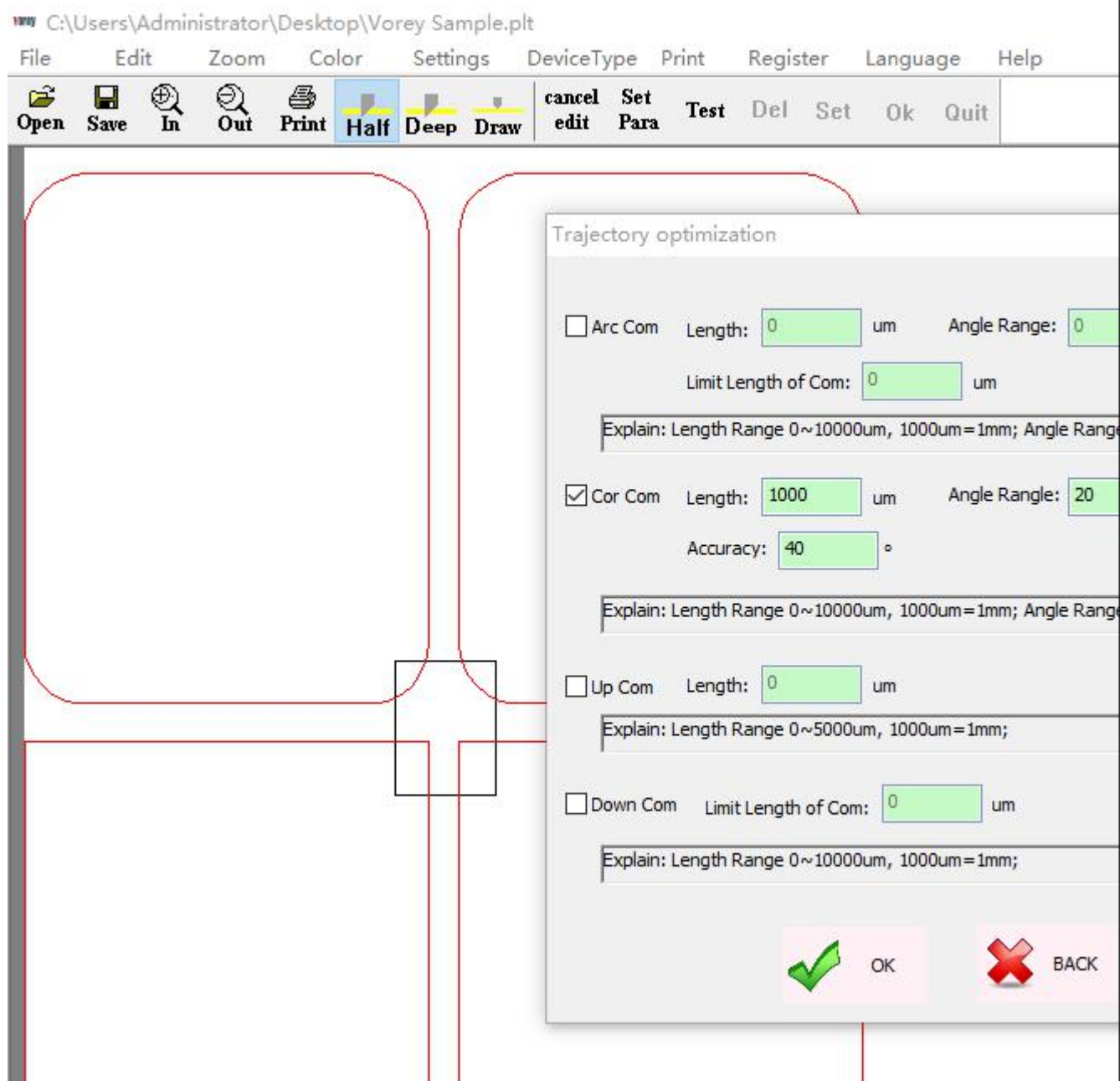
As shown in the figure: when the label is a right angle, use the radius cutter compensation.



Note: The principle of this turning radius compensation is the same as the turning radius compensation in the machine setting. To use it in the software, you need to turn off the turning radius compensation in the machine setting and first click  APPLY then click  OK. The greater the discrete accuracy, the lower the accuracy, and the smaller the higher the accuracy.

5-2-3-13

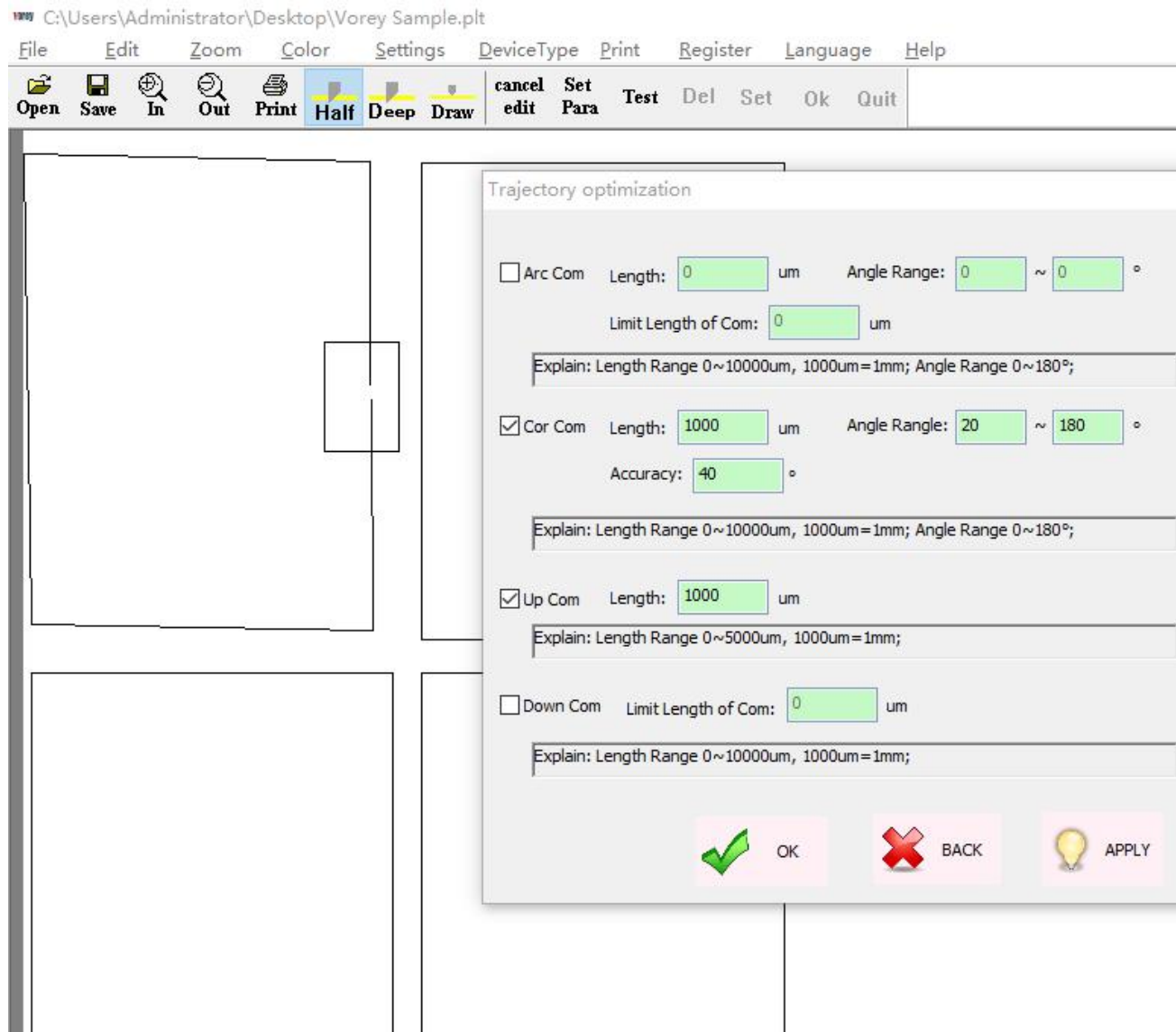
As shown in the figure: when the label is both right and rounded corners, please refer to the radius cutter compensation.





Note: The principle of this turning radius compensation is the same as the turning radius compensation in the machine setting. To use it in the software, you need to turn off the turning radius compensation in the machine setting and first click APPLY then click OK. The greater the discrete accuracy, the higher the accuracy, and the smaller the lower the accuracy.

5-2-3-14

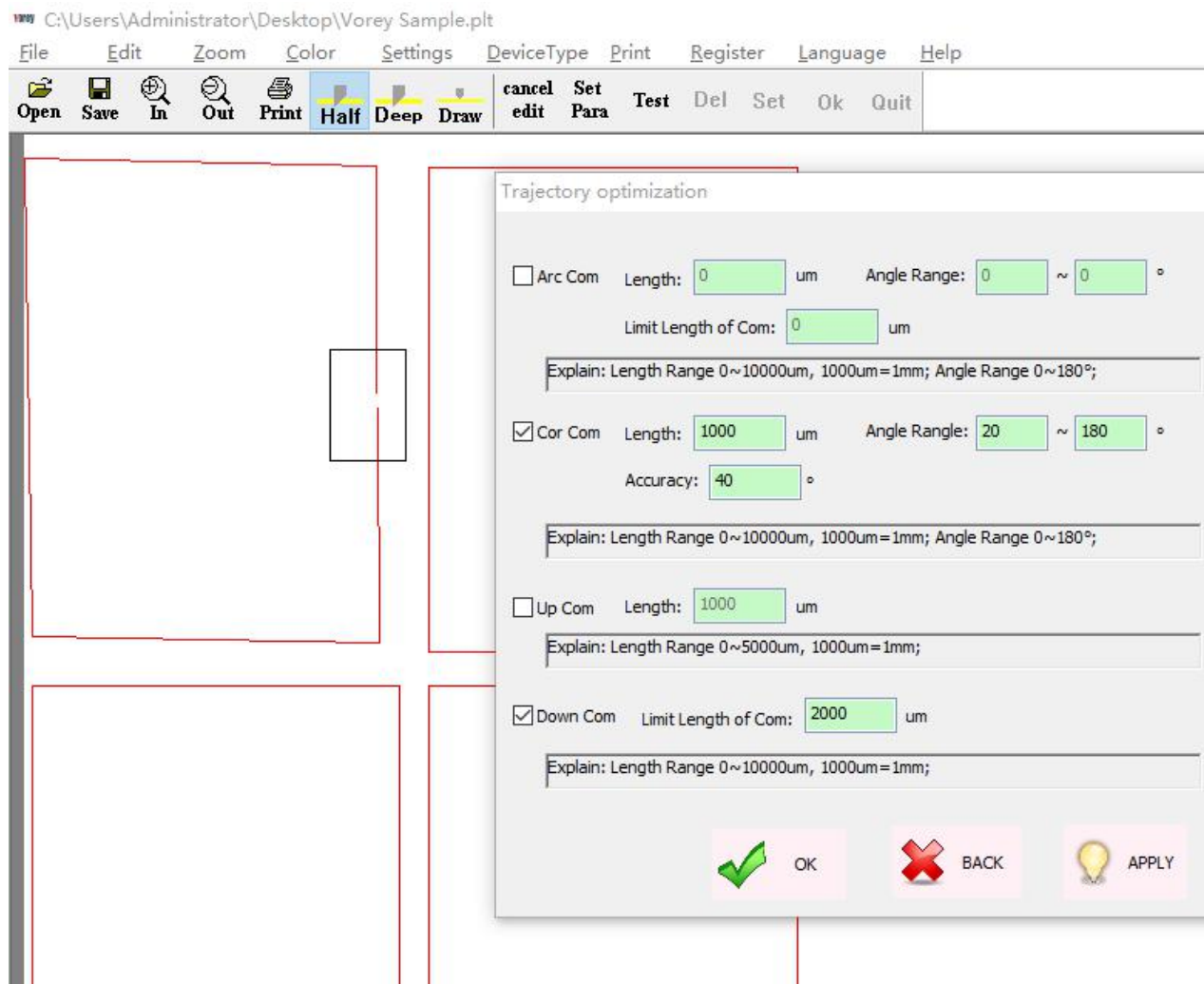
As shown in the figure: the knife drop point and the knife lift point are not connected during cutting.





Note: According to the unconnected length, the compensation is performed before the tool is raised. After the selection is completed, first click  then click .

5-2-3-15

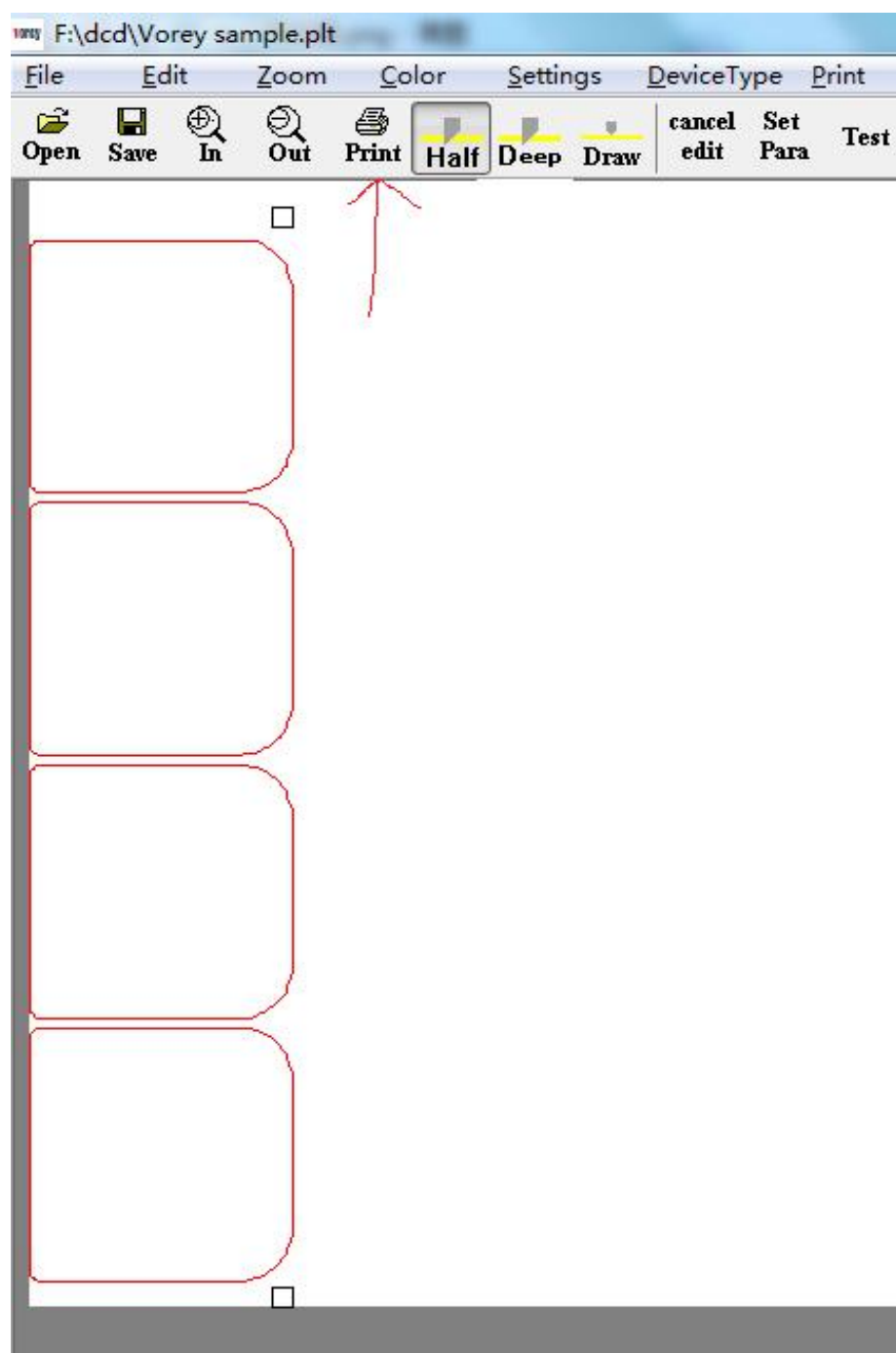
As shown in the figure: the knife drop point and the knife lift point are not connected during cutting.



Note: Set the tool compensation before tool drop according to the unconnected length. After selection, first click  APPLY then click  OK .

5-2-3-16

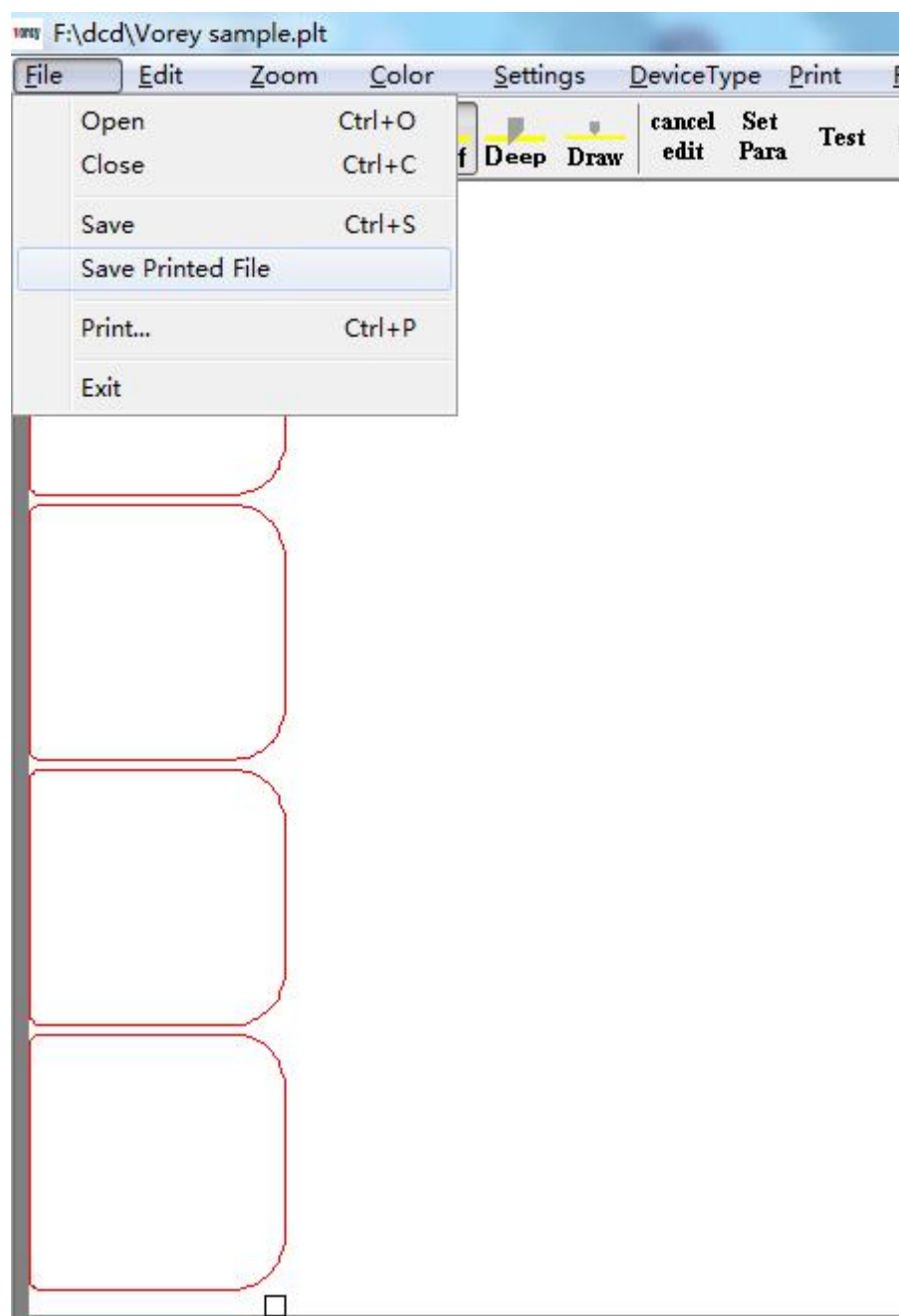
When transferred by network



Click “Print” to output the file to the machine. The machine panel will turn to the interface of heads control.

5-2-3-17

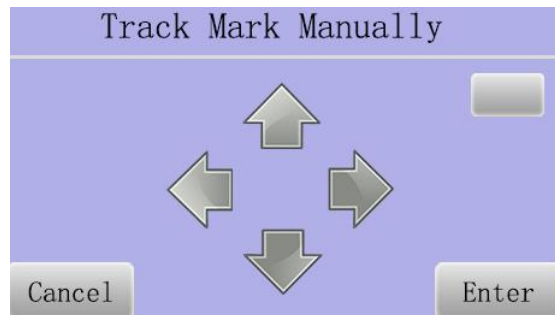
When transferred by USB



Click to save the print file to the U disk. Note: U disk storage files can be recognized at most 8 at the same time, and the name must be English letters and or numbers when saving. .

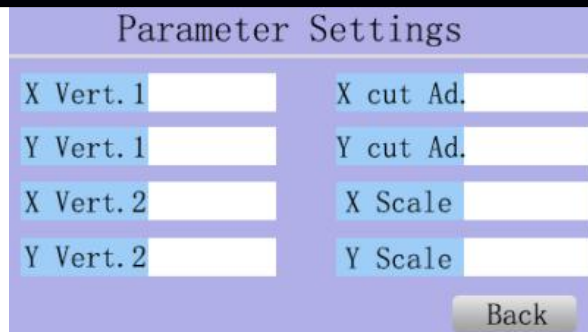
Chapter 6 Getting started

6-1



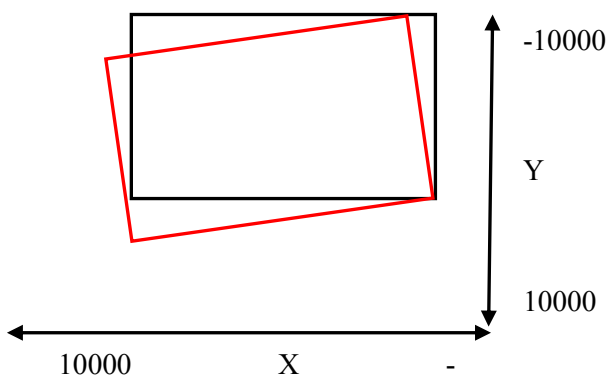
After the file is sent, click the move button on the operation panel to move the positioning sensor on the cutting system to the outermost black mark. Press the Enter key to execute cutting.

6-2



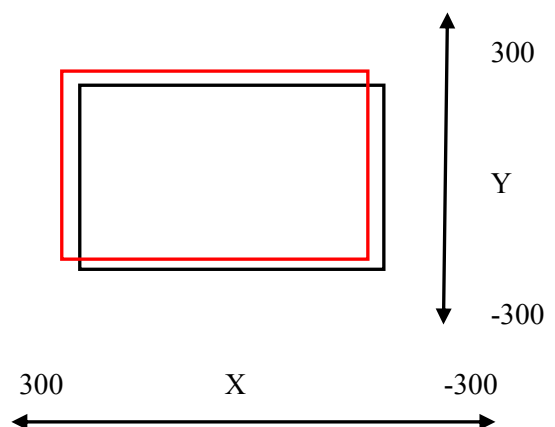
Check the verticality of the cutting path in the X and Y direction, the X and Y cutting position, and the X and Y zoom. If you need to modify the corresponding operation on the panel to modify the correct cutting path.

6-3



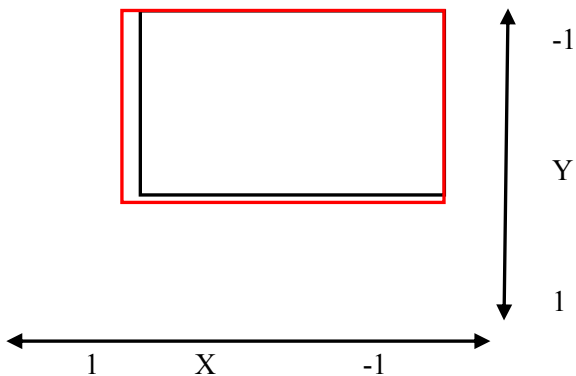
Adjust the X/Y perpendicularity to change the cutting position according to the cutting phenomenon, as shown in the figure.

6-4



According to the cutting phenomenon, adjust the X/Y knife compensation to change the cutting position, as shown in the figure.

6-5



According to the cutting phenomenon, adjust the zoom of X/Y in turn, as shown in the figure.

6-6

After adjustment, check the cutting quality and change the speed accordingly.

Enter the number of job you want to cut on and the number of jobs you want to skip tracking, click the Repeat button, and operate according to 6-1.

6-7



Press the Pause button to pause work. Turn off the rewind governor. Install a paper tube on the core, lock the baffle according to the position, and peel off the bottom paper from the media. Use the waste material to stick it to the waste roll. Turn on the rewind governor and click Continue to keep working.

6-8

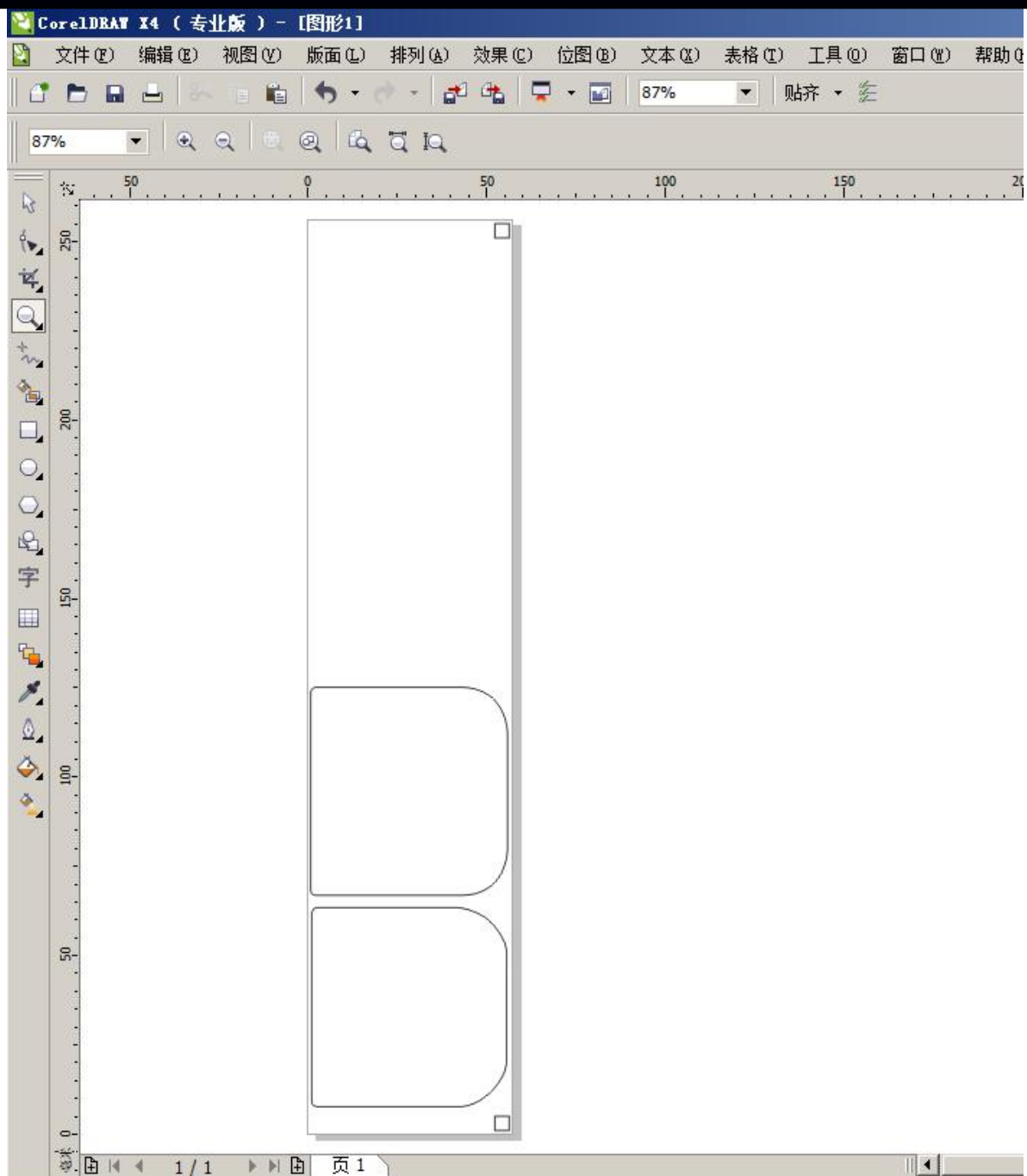


Press the Pause button to pause work. Move the slitting tool and lock it according to the position. Release the slitting blade. Click Continue to keep working.

Please read Chapter 4-6.

Multi-head cutting mode

6-9



If the document is printed repeatedly, use double knives to cut, as shown in the figure: delete half of the cut graphics.

The file lines is 2 or a multiple of 2.

Chapter 7 Equipment Maintenance

7-1 Maintenance

Check the media feeding system parts every day before use. If there is some dust or debris, please clean shaft, roller and board with alcohol and gasoline. You must do the basic clean, the clean rate depends on your use and the media. Dust will block the die-cutting system moving. Caused the moving incorrect, even there is risk and effect the life-span of equipment.

General cleaning and maintenance procedures

1. Confirm machine is power off, and plug is out of socket.
2. Clean the dust and debris inside of machine.
3. Wipe the board with glass cleaner, use soft cloth to wipe dry.
4. Wipe all the slide rails of the motion system with alcohol and cotton cloth. The rollers must be kept clean, because dust will block the rim and cause the wear of the rollers, making the movement system uneven. After the slide rail is cleaned, use a clean cotton swab moistened with alcohol against the roller, and move the motion system with the other hand to rotate the roller while cleaning the roller and the slide rail.

7-2 Troubleshooting

| Panel error info | Issue | Solution |
|---------------------------------|---|---|
| CHECK FAIL | Error communication of panel and main board | ➤ Turn off machine and restart . Otherwise, please contact VICUT |
| Resetting | Resetting sensor error. | Check resetting sensor of XY directions, use metal to touch sensor, if the light is on, check the position of board, and adjust the position. |
| Error when open the serial port | Communication of PC and machine is error. | Check the connection wire, re-insert the port. Check the PC port and software port are ok. |
| Machine lock | To the period of testing | Please contact VICUT |

Common troubleshooting

| Problem | Reason and Solution |
|---|---|
| The cutting depth is different, some backing sheet is cut, and some paper can't cut. | <ol style="list-style-type: none"> 1. The length of blade point is too long: Adjust the length of point to 2/3 of paper. Confirm can't cut backing sheet, adjust the pressure of blade, and confirm paper can be cut correctly. 2. If PVC cutting board has been cut one line, or new board is not smooth, or board is not level, please adjust the board in the level. 3. The concentricity of the blade holder is not good or there are foreign objects. Replace the blade holder. |
| The corner of label is warping. Not smooth. | <ol style="list-style-type: none"> 1. The length of blade point is too long, please adjust. 2. The blade is wearied, please replace blade |
| Label shape is not correct and not complete closed. | <ol style="list-style-type: none"> 1. Pressure of blade is too heavy, or the length of blade pointed it too long, or PVC board is dirty, or PVC board is too soft. Cause the paper move when cutting. 2. The X and Y direction belt too tight. Or gear of motor shaft is loosed, caused die-cutter system moving wrong. 3. If only not closed, you need to set the value of scale in the software. |
| Die-cutter system move in wrong and cutting in wrong | <ol style="list-style-type: none"> 1. Your file is not set correctly in software. 2. Output file is not complete. 3. Software is damaged or computer is virus. 4. some electric welding close to machine, or wireless/Equipment and other interfere this machine. |
| Media feed incorrect | <ol style="list-style-type: none"> 1. Media roller is installed incorrectly. 2. PVC board is too dirty, and glue on the surface, the side of media moving is not stable. caused media feed in the left or right. 3. The pressure The Main feeding roller and laminating roller are unbalance. |
| Track mark is not correct | <ol style="list-style-type: none"> 1. The color of black mark and paper is very similar, and sensibility is low, please adjust of sensibility of sensor. 2. The media sides is not smooth; material edges upturned, can't track mark correctly. |

| | |
|------------------------------------|---|
| Track length is not correct | <ol style="list-style-type: none"> 1. The color of black mark and paper is very similar, and sensibility is low, please adjust of sensibility of sensor. 2. The media sides is not smooth, can't track mark correctly. 3. Media feed incorrect (pls reference Media feed incorrect.) |
| Rewinding incorrect | <ol style="list-style-type: none"> 1. Media installation is incorrect 2. PVC board is too dirty, and glue on that, the side of media moving is not stable. Caused media feed in the left or right. 3. The pressure The Main feeding roller and laminating roller are unbalance. 4. Adjust sensor system is not effect, or system move to limited position. 5. The pressure of Rewinding tense shaft is unbalance. Adjust the pressure. |
| Waste removing incorrect | <ol style="list-style-type: none"> 1. Paper is not cut 2. Shape is not closed. 3. Adjust the angle of removing, angle is wide, removing will be good. 4. Adjust the speed and pressure of shaft, if speed is high, the pressure will be strong, the waste will be break. |

Chapter 8 Warranty

ANHUI WILLIAM(VICUT) CNC Technology Co., Ltd. (“VICUT” hereunder) will provide reasonable monitor and preventive measures to make sure that users can use qualified products. Under any circumstances, VICUT's responsibilities are limited to the contract price and it will not be responsible for the other parts beyond the contract price.

Warranty period:

- A. The warranty period is within 12 months from installation date.
- B. When users receive the product, please inform VICUT immediately if you find any product material or workmanship defect, and VICUT will decide to repair or replace based on detailed condition.
- C. The cost to repair or replace the defective components in the warranty period is borne by VICUT.
- D. Within the warranty period, users shall follow operation guidance strictly to make relevant operations. VICUT does not bear warranty responsibilities to the consequences caused by the following situations:
 - 1) Incorrect installation, storage, use or operation of product.
 - 2) Change or refit the product arbitrarily without consent from VICUT.
 - 3) Product repair done by service personnel without training.
 - 4) Using accessories or consumables supplied by a third party not certified by VICUT.

The above said 12 months warranty period does not apply to wearing parts and consumables as following:

- 1. Rubber roller, slitting roller.
- 2. Cutting holder, blade, slitting unit and razor.
- 3. Rubber belt.

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